

# MOUNTING AND OPERATING INSTRUCTIONS



## EB 8097 EN

### Translation of original instructions



Type 3347/3277 Pneumatic Control Valve  
(cast body) with Type 3725 Positioner



Type 3347/3379 Control Valve (cast body)  
with welding ends and Type 3724 Positioner

## Type 3347 Hygienic Angle Valve

In combination with an actuator, e.g. SAMSON Type 3271,  
Type 3277, Type 3372 or Type 3379 Pneumatic Actuator

Edition June 2021



## Note on these mounting and operating instructions

These mounting and operating instructions assist you in mounting and operating the device safely. The instructions are binding for handling SAMSON devices. The images shown in these instructions are for illustration purposes only. The actual product may vary.

- For the safe and proper use of these instructions, read them carefully and keep them for later reference.
- If you have any questions about these instructions, contact SAMSON's After-sales Service (aftersaleservice@samsongroup.com).



Documents relating to the device, such as the mounting and operating instructions, are available on our website at [www.samsongroup.com](http://www.samsongroup.com) > **Service & Support > Downloads > Documentation.**

## Definition of signal words

### **DANGER**

*Hazardous situations which, if not avoided, will result in death or serious injury*

### **WARNING**

*Hazardous situations which, if not avoided, could result in death or serious injury*

### **NOTICE**

*Property damage message or malfunction*

### **Note**

*Additional information*

### **Tip**

*Recommended action*

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# 1 Safety instructions and measures

## Intended use

The Type 3347 Hygienic Angle Valve in combination with an actuator (e.g. Type 3271, Type 3277, Type 3372 or Type 3379 Pneumatic Actuator) is designed to regulate the flow rate, pressure or temperature of liquids, gases or vapors. The angle valve is suitable for use in hygienic applications (e.g. in the pharmaceutical and biotechnology sectors as well as the food and beverage industry) to meet strict hygienic requirements, such as FDA, 3A and EHEDG. The valve with its actuator is designed to operate under exactly defined conditions (e.g. operating pressure, process medium, temperature). Therefore, operators must ensure that the control valve is only used in operating conditions that meet the specifications used for sizing the valve at the ordering stage. In case operators intend to use the control valve in other applications or conditions than specified, contact SAMSON.

SAMSON does not assume any liability for damage resulting from the failure to use the device for its intended purpose or for damage caused by external forces or any other external factors.

→ Refer to the technical data and nameplate for limits and fields of application as well as possible uses.

## Reasonably foreseeable misuse

The control valve is not suitable for the following applications:

- Use outside the limits defined during sizing and by the technical data
- Use outside the limits defined by the valve accessories connected to the valve

Furthermore, the following activities do not comply with the intended use:

- Use of non-original spare parts
- Performing service and repair work not described

## Qualifications of operating personnel

The control valve must be mounted, started up, serviced and repaired by fully trained and qualified personnel only; the accepted industry codes and practices must be observed. According to these mounting and operating instructions, trained personnel refers to individuals who are able to judge the work they are assigned to and recognize possible hazards due to their specialized training, their knowledge and experience as well as their knowledge of the applicable standards.

Welding operations must only be performed by personnel who has the necessary qualification to perform the applied welding procedure and handle the materials used.

## Safety instructions and measures

### Personal protective equipment

We recommend checking the hazards posed by the process medium being used (e.g.

▶ GESTIS (CLP) hazardous substances database). Depending on the process medium and/or the activity, the protective equipment required includes:

- Protective clothing, gloves, eye protection and respiratory protection in applications with hot, cold and/or corrosive media
  - Wear hearing protection when working near the valve
  - Hard hat
  - Safety harness when working at height
  - Safety footwear, ESD (electrostatic discharge) footwear, if necessary
- ➔ Check with the plant operator for details on further protective equipment.

### Revisions and other modifications

Revisions, conversions or other modifications of the product are not authorized by SAMSON. They are performed at the user's own risk and may lead to safety hazards, for example. Furthermore, the product may no longer meet the requirements for its intended use.

### Safety features

The fail-safe position of the control valve upon air supply or control signal failure depends on the actuator used (see associated actuator documentation). When the valve is combined with a SAMSON Type 3271 or Type 3277 Pneumatic Actuator, the valve moves to a certain fail-safe position (see the 'Design and principle of operation' section) upon supply air or control signal failure. The fail-safe action of the actuator is the same as its direction of action and is specified on the nameplate of SAMSON actuators.

### Warning against residual hazards

To avoid personal injury or property damage, plant operators and operating personnel must prevent hazards that could be caused in the control valve by the process medium, the operating pressure, the signal pressure or by moving parts by taking appropriate precautions. Plant operators and operating personnel must observe all hazard statements, warning and caution notes in these mounting and operating instructions.

Hazards resulting from the special working conditions at the installation site of the valve must be identified in a risk assessment and prevented through the corresponding safety instructions drawn up by the operator.

### Responsibilities of the operator

Operators are responsible for proper use and compliance with the safety regulations. Operators are obliged to provide these mounting and operating instructions as well as the referenced documents to the operating personnel and to instruct them in proper operation. Furthermore, operators must ensure that operating personnel or third parties are not exposed to any danger.

Operators are additionally responsible for ensuring that the limits for the product defined in the technical data are observed. This also applies to the start-up and shutdown procedures. Start-up and shutdown procedures fall within the scope of the operator's duties and, as such, are not part of these mounting and operating instructions. SAMSON is unable to make any statements about these procedures since the operative details (e.g. differential pressures and temperatures) vary in each individual case and are only known to the operator.

### Responsibilities of operating personnel

Operating personnel must read and understand these mounting and operating instructions as well as the referenced documents and observe the specified hazard statements, warnings and caution notes. Furthermore, operating personnel must be familiar with the applicable health, safety and accident prevention regulations and comply with them.

### Referenced standards, directives and regulations

The control valves comply with the requirements of the European Pressure Equipment Directive 2014/68/EU. Valves with a CE marking have a declaration of conformity, which includes information about the applied conformity assessment procedure. The 'Certificates' section contains this declaration of conformity.

According to the ignition risk assessment performed in accordance with ISO 80079-36, section 5.2, the non-electrical control valves do not have their own potential ignition source even in the rare incident of an operating fault. As a result, they do not fall within the scope of Directive 2014/34/EU.

→ For connection to the equipotential bonding system, observe the requirements specified in section 6.4 of EN 60079-14 (VDE 0165-1).

### Referenced documentation

The following documents apply in addition to these mounting and operating instructions:

- Mounting and operating instructions for mounted actuator, e.g. ► EB 8310-X for SAMSON Type 3271 and Type 3277 Actuators, ► EB 8313-X for SAMSON Type 3372 Actuator or ► EB 8315 for SAMSON Type 3379 Actuator
- Mounting and operating instructions for mounted valve accessories (positioner, solenoid valve etc.)
- ► AB 0100 for tools, tightening torques and lubricant
- Manual ► H 02: Appropriate Machinery Components for SAMSON Pneumatic Control Valves with a Declaration of Conformity of Final Machinery
- When a substance is used in the device, which is listed as being a substance of very high concern on the candidate list of the REACH regulation:  
Information on safe use of the part affected  
► [www.samsongroup.com](http://www.samsongroup.com) > About SAMSON > Material Compliance > REACH

If a device contains a substance which is listed as being a substance of very high concern on the candidate list of the REACH regulation, this circumstance is indicated on the SAMSON delivery note.

## 1.1 Notes on possible severe personal injury

### DANGER

#### **Risk of bursting in pressure equipment.**

Valves and pipelines are pressure equipment. Impermissible pressure or improper opening can lead to valve components bursting.

- ➔ Observe the maximum permissible pressure for valve and plant.
- ➔ Before starting any work on the control valve, depressurize all plant sections affected as well as the valve.
- ➔ Drain the process medium from all the plant sections concerned as well as the valve.

## 1.2 Notes on possible personal injury

### WARNING

#### **Risk of burn injuries due to hot or cold components and pipelines.**

Depending on the process medium, valve components and pipelines may get very hot or cold and cause burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.
- Wear protective clothing and safety gloves.

#### **Risk of hearing loss or deafness due to loud noise.**

The noise emissions depend on the valve version, plant facilities and process medium.

- Wear hearing protection when working near the valve.

#### **Risk of personal injury due to exhaust air being vented.**

While the valve is operating, air is vented from the actuator, for example, during closed-loop operation or when the valve opens or closes.

- Install the control valve in such a way that vent openings are not located at eye level and the actuator does not vent at eye level in the work position.
- Use suitable silencers and vent plugs.
- Wear eye protection when working in close proximity to the control valve.

### **WARNING**

#### **Crush hazard arising from moving parts.**

The control valve contains moving parts (actuator and plug stem), which can injure hands or fingers if inserted into the valve.

- Do not insert hands or finger into the yoke while the air supply is connected to the actuator.
- Before working on the control valve, disconnect and lock the pneumatic air supply as well as the control signal.
- Do not impede the movement of the actuator and plug stem by inserting objects into the yoke.
- Before unblocking the actuator and plug stem after they have become blocked (e.g. due to seizing up after remaining in the same position for a long time), release any stored energy in the actuator (e.g. spring compression). See associated actuator documentation.

#### **Risk of personal injury due to preloaded springs.**

Valves in combination with pneumatic actuators with preloaded springs are under tension. These control valves with SAMSON pneumatic actuators can be identified by the long bolts protruding from the bottom of the actuator.

- Before starting any work on the actuator, relieve the compression from the preloaded springs (see associated actuator documentation).

#### **Risk of personal injury due to residual process medium in the valve.**

While working on the valve, residual medium can flow out of the valve and, depending on its properties, cause personal injury, e.g. (chemical) burns.

- If possible, drain the process medium from all the plant sections affected and the valve.
- Wear protective clothing, safety gloves, respiratory protection and eye protection.

**⚠ WARNING****Exposure to hazardous substances poses a serious risk to health.**

Certain lubricants and cleaning agents are classified as hazardous substances. These substances have a special label and a material safety data sheet (MSDS) issued by the manufacturer.

- Make sure that an MSDS is available for any hazardous substance used. If necessary, contact the manufacturer to obtain an MSDS.
- Inform yourself about the hazardous substances and their correct handling.

**Risk of personal injury through incorrect operation, use or installation as a result of information on the valve being illegible.**

Over time, markings, labels and nameplates on the valve may become covered with dirt or become illegible in some other way. As a result, hazards may go unnoticed and the necessary instructions not followed. There is a risk of personal injury.

- Keep all relevant markings and inscriptions on the device in a constantly legible state.
- Immediately renew damaged, missing or incorrect nameplates or labels.

## 1.3 Notes on possible property damage

**ⓘ NOTICE****Risk of valve damage due to contamination (e.g. solid particles) in the pipeline.**

The plant operator is responsible for cleaning the pipelines in the plant.

- Flush the pipelines before start-up.

**Risk of valve damage due to unsuitable medium properties.**

The valve is designed for a process medium with defined properties.

- Only use the process medium specified for sizing the valve.

### ! NOTICE

#### **Risk of leakage and valve damage due to excessively high or low tightening torques.**

Observe the specified torques when tightening control valve components. Excessive tightening torques lead to parts wearing out more quickly. Parts that are too loose may cause leakage.

→ Observe the specified tightening torques (▶ AB 0100).

#### **Risk of valve damage due to the use of unsuitable tools.**

Certain tools are required to work on the valve.

→ Only use tools approved by SAMSON (▶ AB 0100).

#### **Risk of valve damage due to the use of unsuitable lubricants.**

The lubricants to be used depend on the valve material. Unsuitable lubricants may corrode and damage surfaces.

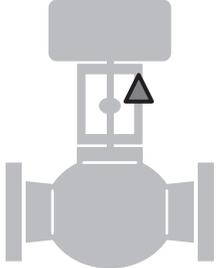
→ Only use lubricants approved by SAMSON (▶ AB 0100).

#### **Risk of the process medium being contaminated through the use of unsuitable lubricants and/or contaminated tools and components.**

→ Keep the valve and the tools used free from solvents and grease.

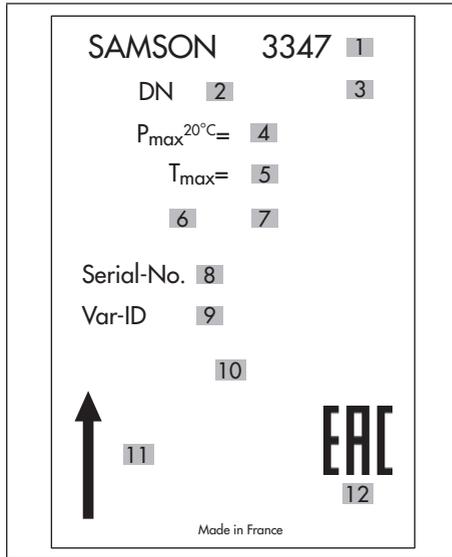
→ Make sure that only suitable lubricants are used.

## 1.4 Warnings on the device

Warning	Meaning of the warning	Location on the device
	Warning against moving parts There is a risk of injury to hands or fingers through the stroking movement of the actuator and plug stem if they are inserted into the yoke while the air supply is connected to the actuator.	

## 2 Markings on the device

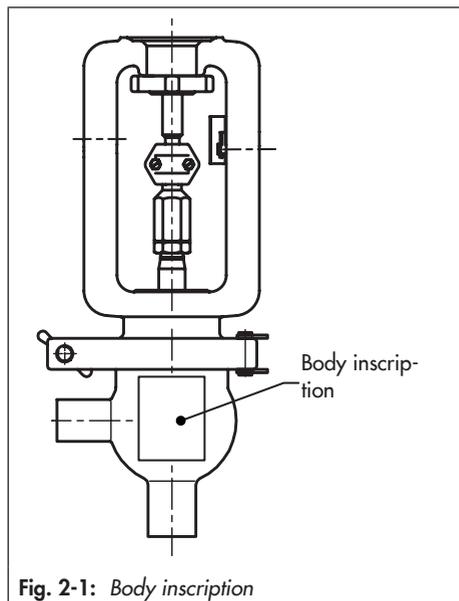
### 2.1 Valve nameplate



- 1 Type designation
- 2 Valve size (DN/NPS/OD)
- 3 Body material
- 4 Maximum pressure at: temperature specified in °C or °F
- 5 Maximum operating temperature (°C or °F)
- 6 Valve flow coefficient according to DIN ( $K_V$ ) or ANSI ( $C_V$ ):  
% = equal percentage or Lin = linear  
Maximum pressure (bar or psi)
- 7 Seat/plug seal  
**ME**: metal · **PK**: soft PEEK seal · **STV**: solid Stellite® · **ST**: metal base material with Stellite® facing · **PT**: soft PTFE seal · **ST/ME**: Stellite®-faced seat/plug with metal seal
- 8 Serial number
- 9 Configuration ID
- 10 Compliance with food industry requirements, if applicable
- 11 PED compliance
- 12 Month and year of production

## Markings on the device

The details on the valve version can be found on the front and back of the valve body (see Fig. 2-1).



## 2.2 Actuator nameplate

See associated actuator documentation.

## 2.3 Material identification number

The valve plug has an item number written on it. The material number of the valve body is used to identify the seat. You can contact us stating these numbers to find out which materials are used.

### 3 Design and principle of operation

See Fig. 3-1 to Fig. 3-4

The Type 3347 Angle Valve is preferably combined with a SAMSON Type 3271 or Type 3277 Pneumatic Actuator. It can also be combined with other actuators (e.g. Type 3372 Electropneumatic Actuator). We recommend using a Type 3379 Pneumatic Actuator for high cleanability requirements.

The standard valve body is designed for welding into pipelines. Other versions can be equipped with threaded or flanged ends or clamp connections.

The control valve is fitted with an easily detachable clamp connection between valve body and bonnet. The body free of dead space is suitable for CIP (Cleaning-In-Place).

The control valves are mainly designed for use as control or on/off valves in the food industry.

The medium flows through the valve in the direction indicated by the arrow. The plug (2) is moved by changing the signal pressure acting on the diaphragm of the actuator.

The plug stem with plug (2) and actuator stem (8.1) are connected by the stem connector (7 or 8.4) and sealed by seals.

In the special version with steam barrier, an additional spring-loaded PTFE ring packing is used. In this case, the plug stem can be cleaned by using a steam barrier.

#### 3.1 Fail-safe position

The fail-safe position of the control valve upon air supply or control signal failure depends on the actuator used (see associated actuator documentation).

Depending on how the compression springs are arranged in the SAMSON pneumatic actuator, the valve has two different fail-safe positions:

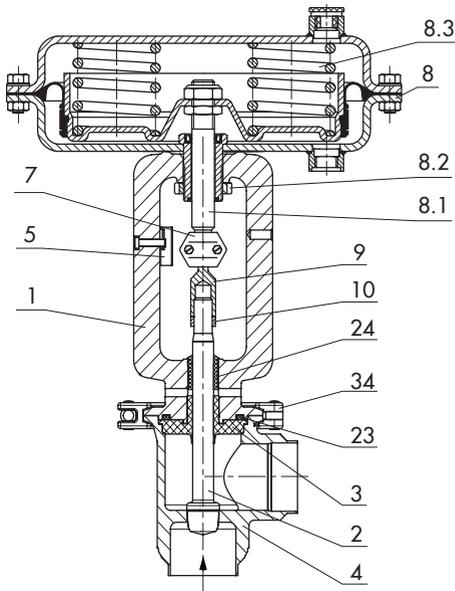
- **Actuator stem extends:** when the signal pressure is reduced or the air supply fails, the springs move the actuator stem downward and close the valve. The valve opens when the signal pressure is increased enough to overcome the force exerted by the springs.
- **Actuator stem retracts:** when the signal pressure is reduced or the air supply fails, the springs move the actuator stem upward and open the valve. The valve closes when the signal pressure is increased enough to overcome the force exerted by the springs.



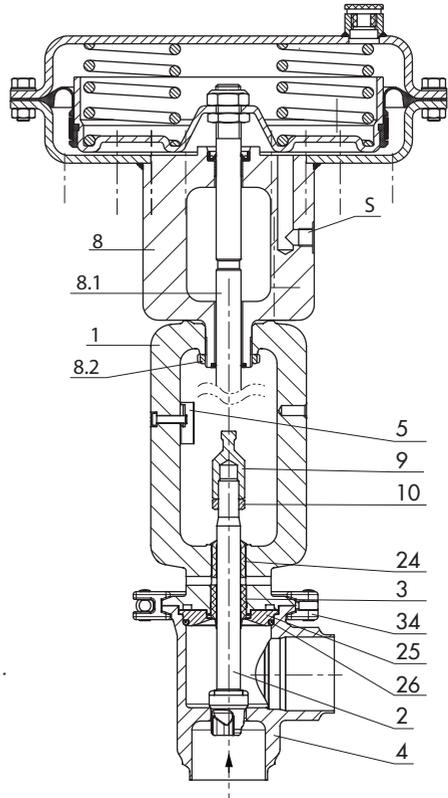
**Tip**  
The actuator's direction of action can be reversed, if required. Refer to the mounting and operating instructions of the pneumatic actuator:

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## Design and principle of operation



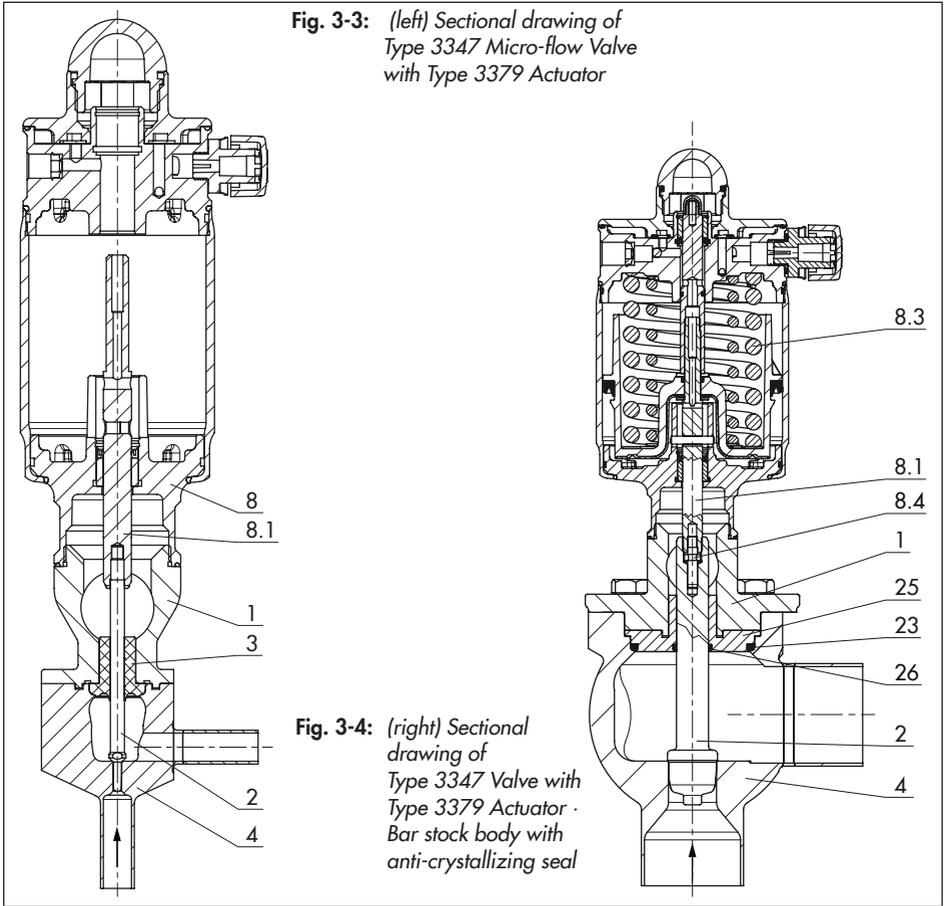
**Fig. 3-1:** (top) Sectional drawing of Type 3347-1 Control Valve (with Type 3271 Actuator) - Cast body with PTFE seal



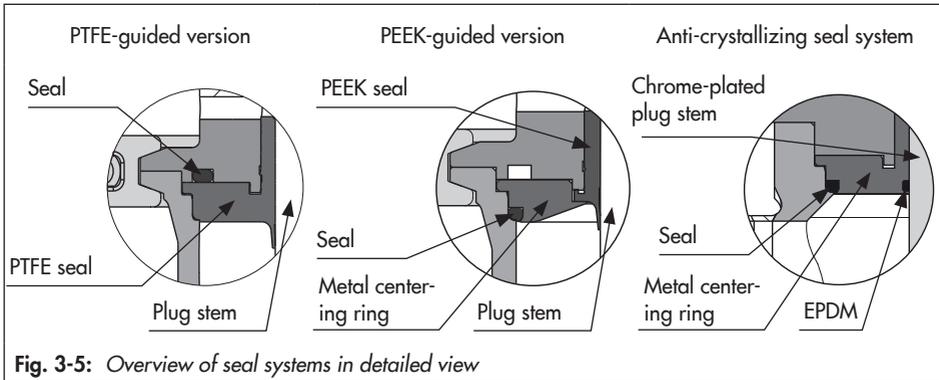
**Fig. 3-2:** (right) Sectional drawing of Type 3347-7 Control Valve (with Type 3277 Actuator) - Cast body with PEEK seal

### Legend for Fig. 3-1 to Fig. 3-4

1 Valve bonnet with yoke	8.1 Actuator stem	24 Guide bushing/wiper ring
2 Plug with plug stem	8.2 Ring nut	25 Centering ring
3 Plug stem seal	8.3 Compression springs	26 Seal
4 Body	8.4 Stem connector	34 Clamps
5 Travel indicator scale	9 Stem connector nut	S Signal pressure connection
7 Stem connector clamps	10 Lock nut	
8 Actuator	23 Seal	



## Design and principle of operation



### 3.2 Versions

#### Steam barrier

A steam barrier can be fitted to sterilize the plug stem with either steam or a sterile fluid.

#### Heating jacket

Details on request

#### Anti-crystallizing seal

The bonnet can be fitted with an anti-crystallizing seal.

#### Connections

The valve is available with various end connections (e.g. welding ends, threaded couplings, clamp connections or flanges) depending on the valve version.

#### High-pressure versions

A high-pressure version with bolted bonnet is available for pressure rating PN 40 (higher pressure ratings on request).

#### Micro-flow valve version

A micro-flow valve version is available for valve sizes DN 6 to 15 (NPS ¼ to ½) up to max. 40 bar (580 psi).

#### Actuators

In these instructions, the preferable combination with a SAMSON Type 3271 or Type 3277 Pneumatic Actuator is described.

Other actuators (e.g. Type 3372 Electro-pneumatic Actuator or Type 3379 Pneumatic Actuator) can also be used.

The pneumatic actuator (with or without handwheel) can be replaced by another pneumatic actuator in a different size, but with the same travel.

→ Observe the maximum permissible actuator force.

**i Note**

*If the travel range of the actuator is larger than the travel range of the valve, the spring assembly in the actuator must be preloaded so that the travel ranges match. See associated actuator documentation.*

### 3.3 Additional fittings

#### Strainers

We recommend installing a SAMSON strainer upstream of the valve. It prevents solid particles in the process medium from damaging the valve.

#### Bypass and shut-off valves

We recommend installing a shut-off valve both upstream of the strainer and downstream of the valve and installing a bypass line. The bypass ensures that the plant does not need to be shut down for service and repair work on the valve.

#### Safety guard

For operating conditions that require increased safety (e.g. in cases where the valve is freely accessible to untrained staff), a safety guard must be installed to rule out a crush hazard arising from moving parts (actuator and plug stem). Plant operators are responsible for deciding whether a guard is to be used. The decision is based on the risk posed by the plant and its operating conditions.

### 3.4 Accessories

Information Sheet ► T 8350

**i Note**

*Any devices mounted on 3-A-compliant valves must also comply with 3-A regulations.*

### 3.5 Technical data

The nameplates on the valve and actuator provide information on the control valve version. See the 'Markings on the device' section.

**i Note**

*More information is available in the following data sheets:*

- T 8097 for Type 3347 Hygienic Angle Valve with Type 3271/3277 or Type 3379
- T 8097-1 for Type 3347/3372 Pneumatic Control Valve

#### Noise emissions

SAMSON is unable to make general statements about noise emissions. The noise emissions depend on the valve version, plant facilities and process medium.

## Design and principle of operation

### Conformity

See Table 3-1

The Type 3347 Valve bears both the CE and EAC marks of conformity.

Other certification:

- FDA
- EHEDG <sup>1)</sup>

The available end connections and body clamps meet the EHEDG guidelines (► <https://www.ehedg.org>).

- 3-A <sup>1)</sup>

More information ► <http://www.3-a.org>

- <sup>1)</sup> Certification not available for all versions. Contact SAMSON for more information.

**Table 3-1:** Technical data for Type 3347 Valve

Body version <sup>1)</sup>	Micro-flow valve	Casting	Bar stock	
Valve size	DN 6 to 25 (NPS ¼ to 1)	DN 25 to 100 (NPS 1 to 4) <sup>3)</sup>	DN 15 to 150 (NPS ½ to 6)	
Body/bonnet connection	Bolted	Clamped	Clamped	Bolted
Maximum pressure (see Data Sheet ► T 8097 for restrictions)	16 bar (230 psi)	16 bar (230 psi)	16 bar (230 psi)	63 bar (914 psi) <sup>4)</sup>
Seat-plug seal	Metal seal · Soft seal			
Characteristic	Equal percentage or linear			
Rangeability	Data Sheet ► T 8097			
Permissible medium temperature	-10 to 150 °C (14 to 300 °F) (see Data Sheet ► T 8097 for restrictions)			
Leakage class according to IEC 60534-4 or ANSI/FCI 70-2	Metal seal	IV		
	Soft seal	-	VI	
Surface quality	External	Glass bead blasted		
		Ra ≤ 0.6 µm · Polished		
	Internal	Ra ≤ 0.8 µm · Fine machine finish		
		Ra ≤ 0.6 µm · Polished		
		Ra ≤ 0.4 µm · Satin finish		
Ra ≤ 0.4 µm · Mirror finish				

Body version <sup>1)</sup>	Micro-flow valve	Casting	Bar stock	
Valve size	DN 6 to 25 (NPS ¼ to 1)	DN 25 to 100 (NPS 1 to 4) <sup>3)</sup>	DN 15 to 150 (NPS ½ to 6)	
Body/bonnet connection	Bolted	Clamped	Clamped	Bolted
Maximum pressure (see Data Sheet ► T 8097 for restrictions)	16 bar (230 psi)	16 bar (230 psi)	16 bar (230 psi)	63 bar (914 psi) <sup>4)</sup>
Versions with 3-A certification	Valve size DN/NPS	25 to 100 / 1 to 4	15 to 125/½ to 4	
	K <sub>Vs</sub> /C <sub>V</sub>	0.4 to 200/0.5 to 190	0.4 to 200/0.5 to 190	
	Connection	Data Sheet ► T 8097		
	Body material	1.4404/316L · 1.4435/316L Generally AISI 300 (except for 301, 302, 303)	1.4404/316L · 1.4435/316L Generally AISI 300 (except for 301, 302, 303)	
	Internal surface finish	Ra ≤ 0.8 µm		
	Seat-plug seal	Metal seal · Soft seal		
	Plug stem guide	PTFE, PEEK and anti-crystallizing seal system		
	Other	Actuator and valve accessories mounted to meet 3-A regulation requirements.		
	Comments	Seals compliant with 3-A regulations must be used on site by the end user.		
	Version with EHEDG certification (Type EL Class I)	Valve size DN/NPS	25 to 100 / 1 to 4	32 to 100/1¼ to 4
K <sub>Vs</sub> /C <sub>V</sub>		0.4 to 160/0.5 to 190	0.4 to 160/2 to 190	
Connection		Data Sheet ► T 8097		
Body material		1.4409/CF3M	1.4404/316L · 1.4435/316L	
Internal surface finish		Ra ≤ 0.8 µm		
Seat-plug seal		Metal seal		
Plug stem guide		PTFE guide		
Leakage detection		Yes		
Comments	Seals compliant with EHEDG requirements must be used on site by the end user.			
Other certification	CFR Title 21 FDA Regulation (EC) No. 1935/2004 Regulation (EU) No. 10/2011 Regulation (EC) No. 2023/2006 USP-VI 121 °C ADI free			

## Design and principle of operation

Body version <sup>1)</sup>	Micro-flow valve	Casting	Bar stock	
Valve size	DN 6 to 25 (NPS ¼ to 1)	DN 25 to 100 (NPS 1 to 4) <sup>3)</sup>	DN 15 to 150 (NPS ½ to 6)	
Body/bonnet connection	Bolted	Clamped	Clamped	Bolted
Maximum pressure (see Data Sheet ▶ T 8097 for restrictions)	16 bar (230 psi)	16 bar (230 psi)	16 bar (230 psi)	63 bar (914 psi) <sup>4)</sup>
Conformity <sup>2)</sup>				

<sup>1)</sup> Suitable for Group 2 fluids according to European Pressure Equipment Directive 2014/68/EU

<sup>2)</sup> CE compliance only for versions in DN 32 with 40 bar (NPS 1¼ with 580 psi) and higher; Article 3, Paragraph 3 of PED applies to all other versions

<sup>3)</sup> DN 15 on request

<sup>4)</sup> Maximum pressure depends on the valve end connections

### Table 3-2: Materials

Table 3-2.1: Type 3347 Valve

Component	Version	Material		
		DIN	ANSI	AFNOR
Body version with lathed seat	Casting	1.4409	CF3M	Z2 CND 17-12
	Bar stock	1.4404/1.4435 <sup>1)</sup>	316L <sup>1)</sup>	Z2 CND 17-12
	Micro-flow valve (bar stock)	1.4435	316L	Z2 CND 17-12
Bonnet		1.4404 <sup>1)</sup>	316L <sup>1)</sup>	Z2 CND 17-12
Plug		1.4404 <sup>1)</sup> · Stellite® coating	316L <sup>1)</sup> · Stellite® coating	Z2 CND 17-12 · Stellite® coating

<sup>1)</sup> Other materials available on request

**Table 3-2.2:** Type 3379 Pneumatic Actuator

Component	Material
Housing and cover	Stainless steel 1.4404/1.4409
Actuator stem	1.4404
Piston	Polyamide, glass fiber reinforced
Dome (visual indicator)	Polycarbonate
Bearing	Polymer
Spring	Spring steel, powder coated
Seals	NBR

**Refer to the following data sheets for dimensions and weights:**

- ▶ T 8097 for Type 3347 Hygienic Angle Valve
- ▶ T 8097-1 for Type 3347/3372 Pneumatic Control Valve

**i Note**

Refer to the following data sheets as well as mounting and operating instructions for dimensions and weights of the SAMSON pneumatic actuators:

- ▶ T 8310-1 for Type 3271 or Type 3277 Pneumatic Actuators up to 750 cm<sup>2</sup> actuator area
- ▶ T 8313 for Type 3372 Actuator
- ▶ EB 8315 for Type 3379 Actuator



## 4 Shipment and on-site transport

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

### 4.1 Accepting the delivered goods

After receiving the shipment, proceed as follows:

1. Check the scope of delivery. Check that the specifications on the valve nameplate match the specifications in the delivery note. See the 'Markings on the device' section for nameplate details.
2. Check the shipment for transportation damage. Report any damage to SAMSON and the forwarding agent (refer to delivery note).
3. Determine the weight and dimensions of the units to be lifted and transported in order to select the appropriate lifting equipment and lifting accessories. Refer to the transport documents and the 'Technical data' section.

### 4.2 Removing the packaging from the valve

Observe the following sequence:

- Do not open or remove the packaging until immediately before lifting to install the valve into the pipeline.

- Leave the control valve in its transport container or on the pallet to transport it on site.
- Do not remove the protective caps from the inlet and outlet until immediately before installing the valve into the pipeline. They prevent foreign particles from entering the valve.
- Dispose and recycle the packaging in accordance with the local regulations.

### 4.3 Transporting and lifting the valve

---

#### **⚠ DANGER**

***Danger due to suspended loads falling.***

- *Stay clear of suspended or moving loads.*
  - *Close off and secure the transport paths.*
- 

#### **⚠ WARNING**

***Risk of lifting equipment tipping over and risk of damage to lifting accessories due to exceeding the rated lifting capacity.***

- *Only use approved lifting equipment and accessories whose minimum lifting capacity is higher than the weight of the valve (including actuator and packaging, if applicable).*
-

---

### **⚠ WARNING**

**Risk of personal injury due to the control valve tipping over.**

- ➔ Observe the valve's center of gravity.
  - ➔ Secure the valve against tipping over or turning.
- 

### **⚠ WARNING**

**Risk of injury due to incorrect lifting without the use of lifting equipment.**

Lifting the control valve without the use of lifting equipment may lead to injuries (back injury in particular) depending on the weight of the control valve.

- ➔ Observe the occupational health and safety regulations valid in the country of use.
- 

### **ⓘ NOTICE**

**Risk of valve damage due to incorrectly attached slings.**

The lifting eyelet/eyebolt on SAMSON actuators is only intended for mounting and removing the actuator as well as lifting the actuator without valve. Do not use this lashing point to lift the entire control valve assembly.

- ➔ When lifting the control valve, make sure that the slings attached to the valve body bear the entire load.
  - ➔ Do not attach load-bearing slings to the actuator, handwheel or any other parts.
  - ➔ Observe lifting instructions (see section 4.3.2).
- 

---

### **💡 Tip**

A swivel hoist can be screwed into SAMSON actuators with a female thread on the top diaphragm case in place of the eye-bolt (see associated actuator documentation).

In contrast to the lifting eyelet/eyebolt, the swivel hoist is designed for setting a control valve assembly upright.

The sling between the swivel hoist and rigging equipment (hook, shackle etc.) must not bear any load when lifting a control valve assembly. The sling only protects the control valve from tilting while being lifted.

---

### **💡 Tip**

Our after-sales service can provide more detailed transport and lifting instructions on request.

---

## 4.3.1 Transporting the valve

The control valve can be transported using lifting equipment (e.g. crane or forklift).

- ➔ Leave the control valve in its transport container or on the pallet to transport it.
- ➔ Observe the transport instructions.

### **Transport instructions**

- Protect the control valve against external influences (e.g. impact).
  - Do not damage the corrosion protection (paint, surface coatings). Repair any damage immediately.
-

- Protect the piping and any mounted valve accessories against damage.
- Protect the control valve against moisture and dirt.
- The permissible transportation temperature of standard control valves is –20 to +65 °C.

---

**i Note**

Contact our after-sales service for the transportation temperatures of other valve versions.

---

### 4.3.2 Lifting the valve

To install a large valve into the pipeline, use lifting equipment (e.g. crane or forklift) to lift it.

#### Lifting instructions

- Use a hook with safety latch to secure the slings from slipping off the hook during lifting and transporting.
- Secure slings against slipping.
- Make sure the slings can be removed from the valve once it has been installed into the pipeline.
- Prevent the control valve from tilting or tipping over.
- Do not leave loads suspended when interrupting work for longer periods of time.
- Make sure that the axis of the plug stem remains in the vertical position during lifting.

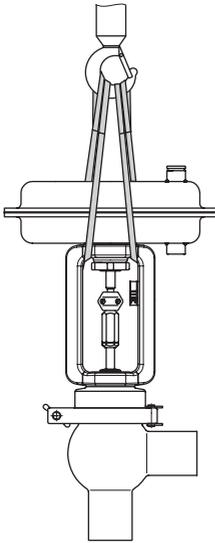
#### Lifting the control valve

1. **With Type 3271/3277 or Type 3372:** carefully guide two slings around the flange and attach them to the rigging equipment of the crane or forklift (see Fig. 4-1, Fig. 4-2 and Fig. 4-3). Make sure that the actuator stem and valve accessories are not damaged.

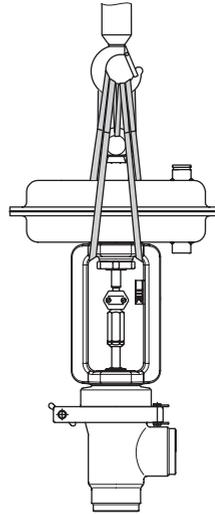
For actuator versions with lifting eyelet, attach an additional sling to the lifting eyelet of the actuator and to the rigging equipment of the crane or forklift (see Fig. 4-2).

**With Type 3379 Actuator:** carefully guide two slings around the actuator. Secure the slings against slipping by using a connector (see Fig. 4-4).

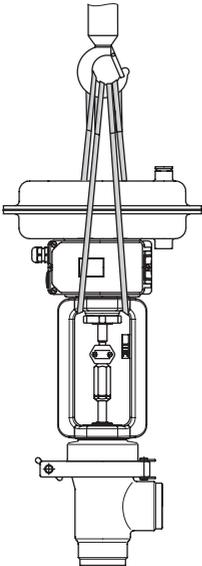
2. Carefully lift the control valve. Check whether the lifting equipment and accessories can bear the weight.
3. Move the control valve at an even pace to the site of installation.
4. Install the valve into the pipeline (see the 'Installation' section).
5. After installation into the pipeline: depending on the type of connection (e.g. welding joint, flanged joint etc.) check whether the valve in the pipeline holds.
6. Remove slings.



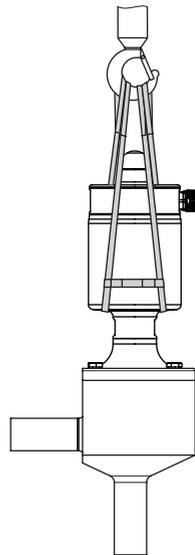
**Fig. 4-1:** Type 3347 with Type 3271 without lifting eyelet



**Fig. 4-2:** Type 3347 with Type 3271 with lifting eyelet



**Fig. 4-3:** Type 3347 with Type 3277 without lifting eyelet



**Fig. 4-4:** Type 3347/3379

## 4.4 Storing the valve

### NOTICE

**Risk of valve damage due to improper storage.**

- Observe the storage instructions.
- Avoid long storage times.
- Contact SAMSON in case of different storage conditions or longer storage times.

### Note

We recommend regularly checking the control valve and the prevailing storage conditions during long storage periods.

### Storage instructions

- Protect the control valve against external influences (e.g. impact).
- Do not damage the corrosion protection (paint, surface coatings). Repair any damage immediately.
- Protect the control valve against moisture and dirt. Store it at a relative humidity of less than 75 %. In damp spaces, prevent condensation. If necessary, use a drying agent or heating.
- Make sure that the ambient air is free of acids or other corrosive media.
- The permissible storage temperature of standard control valves is  $-20$  to  $+65$  °C. Contact our after-sales service for the storage temperatures of other valve versions.

- Do not place any objects on the control valve.

### Special storage instructions for elastomers

Elastomer, e.g. actuator diaphragm

- To keep elastomers in shape and to prevent cracking, do not bend them or hang them up.
- We recommend a storage temperature of  $15$  °C for elastomers.
- Store elastomers away from lubricants, chemicals, solutions and fuels.

### Tip

SAMSON's After-sales Service can provide more detailed storage instructions on request.



## 5 Installation

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

### 5.1 Installation conditions

#### Work position

The work position for the control valve is the front view looking onto the operating controls (including valve accessories).

Plant operators must ensure that, after installation of the device, the operating personnel can perform all necessary work safely and

easily access the device from the work position.

#### Pipeline routing

The inlet and outlet lengths (see Table 5-1) vary depending on several variables and process conditions and are intended as recommendations. Contact SAMSON if the lengths are significantly shorter than the recommended lengths.

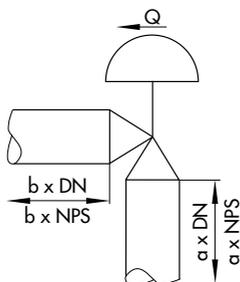
To ensure that the valve functions properly, proceed as follows:

- ➔ Observe the inlet and outlet lengths (see Table 5-1). Contact SAMSON if the

**Table 5-1:** *Inlet and outlet lengths*

State of process medium	Valve conditions	Inlet length a	Outlet length b
Gas	$Ma \leq 0.3$	2	4
Vapor	$Ma \leq 0.3$ <sup>1)</sup>	2	4
Liquid	Free of cavitation/ $w < 10$ m/s	2	4
	Cavitation producing noise/ $w \leq 3$ m/s	2	4
	Cavitation producing noise/ $3 < w < 5$ m/s	2	10

<sup>1)</sup> No wet steam



Q Flow rate  
a Inlet length  
b Outlet length

## Installation

valve conditions or states of the medium process deviate.

- Install the valve free of stress and with the least amount of vibrations as possible. Read information under 'Mounting position' and 'Support or suspension' in this section.
- Install the valve allowing sufficient space to remove the actuator and valve or to perform service work on them.

### Mounting position

To ensure that the valve can be drained and cleaned properly, we recommend installing the valve with the actuator upright and on top of the valve.

- Contact SAMSON if the mounting position is not as specified above.

### Support or suspension

---

#### **i** Note

*The plant engineering company is responsible for selecting and implementing a suitable support or suspension of the installed control valve and the pipeline.*

---

Depending on the valve version and mounting position, the valve, actuator and pipeline must be supported or suspended.

Valves, which are not installed in the pipeline in the upright position with the actuator on top, must be supported or suspended.

### Valve accessories

- During connection of valve accessories, make sure that they are easily accessible

and can be operated safely from the work position.

### Vent plugs

Vent plugs are screwed into the exhaust air ports of pneumatic and electropneumatic devices. They ensure that any exhaust air that forms can be vented to the atmosphere (to avoid excess pressure in the device). Furthermore, the vent plugs allow air intake to prevent a vacuum from forming in the device.

- Locate the vent plug on the opposite side to the work position of operating personnel.

## 5.2 Preparation for installation

Before installation, make sure the following conditions are met:

- The valve is clean.
- The valve and all valve accessories (including piping) are not damaged.
- The valve data on the nameplate (type designation, valve size, material, pressure rating and temperature range) match the plant conditions (size and pressure rating of the pipeline, medium temperature etc.). See the 'Markings on the device' section for nameplate details.
- The requested or required additional pipe fittings (see the 'Additional fittings' section) have been installed or prepared as necessary before installing the valve.

Proceed as follows:

- ➔ Lay out the necessary material and tools to have them ready during installation work.
- ➔ Flush the pipelines.

### **i** Note

*The plant operator is responsible for cleaning the pipelines in the plant.*

- ➔ For steam applications, dry the pipelines. Moisture will damage the inside of the valve.
- ➔ Check any mounted pressure gauges to make sure they function properly.
- ➔ When the valve and actuator are already assembled, check the connections

to ensure they are seated correctly. Components may loosen during transport.

## 5.3 Mounting the device

The activities listed below are necessary to install the valve and before it can be started up.

### **!** NOTICE

***Risk of the process medium being contaminated through the use of unsuitable lubricants and/or contaminated tools and components.***

- ➔ *Keep the valve and the tools used free from solvents and grease.*
- ➔ *Make sure that only suitable lubricants are used (▶ AB 0100).*

### **!** NOTICE

***Risk of valve damage due to excessively high or low tightening torques.***

*Observe the specified torques when tightening control valve components. Excessive tightening torques lead to parts wearing out more quickly. Parts that are too loose may cause leakage.*

- ➔ *Observe the specified tightening torques (▶ AB 0100).*

### **!** NOTICE

***Risk of valve damage due to the use of unsuitable tools.***

- ➔ *Only use tools approved by SAMSON (▶ AB 0100).*

### NOTICE

**Risk of control valve damage due to incorrect handling.**

Make sure that the stem seal is not damaged.

→ The plug must not be moved beyond the valve travel.

### 5.3.1 Mounting the actuator onto the valve

### WARNING

**Risk of personal injury due to preloaded springs.**

Actuators with preloaded springs are under tension. They can be identified by the long bolts protruding from the bottom of the actuator.

→ Before starting any work on the actuator, relieve the compression from the preloaded springs (see associated actuator documentation).

Depending on the version, SAMSON control valves are either delivered with the actuator already mounted on the valve or the valve and actuator are delivered separately. When delivered separately, the valve and actuator must be assembled together on site.

A valve assembly fitted with a SAMSON Type 3379 Pneumatic Actuator is always delivered with the actuator ready mounted.

### Versions with V-port plug and Type 3271/3277 or Type 3372 Actuator

To achieve the best flow conditions inside the valve, the V-port plug must always be installed with the port that releases the flow first when the valve opens facing toward the valve outlet. This is the largest of the three V-shaped ports (see Fig. 5-1).

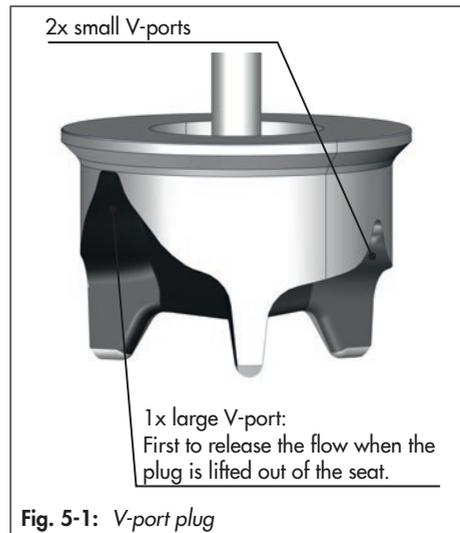


Fig. 5-1: V-port plug

- Before mounting the actuator, determine which V-shaped port is uncovered first when the plug is lifted out of the seat.
- On mounting the actuator, make sure that the V-shaped port uncovered first faces toward the valve outlet:
- To mount the actuator, proceed as described in the associated actuator documentation, e.g.:

- ► EB 8310-1 for Type 3271 and Type 3277 Pneumatic Actuators with 120 cm<sup>2</sup> actuator area
  - ► EB 8310-4 for Type 3271 and Type 3277 Pneumatic Actuators with 355v2 cm<sup>2</sup> actuator area
  - ► EB 8310-5 for Type 3271 and Type 3277 Pneumatic Actuators with 175v2, 350v2 and 750v2 cm<sup>2</sup> actuator areas
  - ► EB 8310-6 for Type 3271 and Type 3277 Pneumatic Actuators with 240, 350 and 700 cm<sup>2</sup> actuator areas
  - ► EB 8313-1 for Type 3372 Electro-pneumatic Actuator with integrated i/p converter
  - ► EB 8313-3 for Type 3372 Electro-pneumatic Actuator with 120 and 350 cm<sup>2</sup> actuator areas and Type 3725 Positioner
  - ► EB 8315 for Type 3379 Pneumatic Actuator
- After the control valve has been installed in the pipeline, attach the required connections to the actuator mounted on the valve.

### 5.3.2 Installing the valve into the pipeline

#### ! NOTICE

**Risk of valve damage due to work being carried out by personnel not qualified for such tasks.**

*The plant operator or specialist company performing the welding is responsible for the selection of the welding procedure and the actual welding operations on the valve. This also applies to any required heat treatment to be performed on the valve.*

→ Only allow qualified welding personnel to carry out welding operations.

#### a) Version with welding ends

1. Close the shut-off valves in the pipeline at the inlet and outlet of the plant section while the valve is being installed.
2. Prepare the relevant section of the pipeline for installing the valve.
3. Remove the protective caps from the valve ports before installing the valve.
4. Lift the valve to the site of installation (see the 'Lifting the valve' section). Observe the flow direction through the valve. The arrow on the valve indicates the direction of flow.
5. Undo the clamp and remove the entire valve-actuator extension from the valve body.
6. Weld the valve body free of stress into the pipeline.

7. Mount the valve-actuator extension back onto the valve body and fasten the clamp.
8. Attach a support or suspension on the valve, if necessary.
9. **Version with steam barrier:** connect the compression-type fittings to the steam supply line.

### b) Valve with flanges, threaded ends or clamp connections:

#### **i** Note

To meet 3-A conformity requirements, a gasket recommended by 3-A Sanitary Standards Inc. (see website

▶ <http://www.3-a.org>) must be used for a Type 3347 Valve with threaded ends according to DIN 11851/DIN 11887.

1. Proceed as described for 'Version with welding ends' (steps 1 to 4).
2. Make sure that the correct flange gaskets are used.
3. Bolt the valve to the pipe free of stress or fasten the clamp connections to the pipe.
4. Proceed as described for 'Version with welding ends' (steps 8 to 9).

## 5.4 Testing the installed valve

### **⚠ DANGER**

#### **Risk of bursting due to incorrect opening of pressurized equipment or components.**

Valves and pipelines are pressure equipment that may burst when handled incorrectly. Flying projectile fragments or the release of process medium under pressure can cause serious injury or even death.

Before working on the control valve:

- Depressurize all plant sections affected and the valve (including the actuator). Release any stored energy.
- Drain the process medium from all the plant sections concerned as well as the valve.

### **⚠ WARNING**

#### **Risk of hearing loss or deafness due to loud noise.**

Noise emission (e.g. cavitation or flashing) may occur during operation caused by the process medium and the operating conditions. Additionally, a loud noise may briefly occur through the sudden venting of the pneumatic actuator or pneumatic valve accessories not fitted with noise-reducing fittings. Both can damage hearing.

- Wear hearing protection when working near the valve.

**⚠ WARNING****Crush hazard arising from actuator and plug stem moving.**

- Do not insert hands or finger into the yoke while the air supply is connected to the actuator.
- Before working on the control valve, disconnect and lock the pneumatic air supply as well as the control signal.
- Do not impede the movement of the actuator and plug stem by inserting objects into the yoke.
- Before unblocking the actuator and plug stem after they have become blocked (e.g. due to seizing up after remaining in the same position for a long time), release any stored energy in the actuator (e.g. spring compression). See associated actuator documentation.

**⚠ WARNING****Risk of personal injury due to exhaust air being vented.**

While the valve is operating, air is vented from the actuator, for example, during closed-loop operation or when the valve opens or closes.

- Wear eye protection when working in close proximity to the control valve.

**⚠ WARNING****Risk of personal injury due to preloaded springs.**

Actuators with preloaded springs are under tension. They can be identified by the long

bolts protruding from the bottom of the actuator.

- Before starting any work on the actuator, relieve the compression from the preloaded springs (see associated actuator documentation).

To test the valve functioning before start-up or putting back the valve into operation, perform the following tests:

**5.4.1 Leak test**

The plant operator is responsible for performing the leak test and selecting the test method. The leak test must comply with the requirements of the national and international standards that apply at the site of installation.

**💡 Tip**

Our after-sales service can support you to plan and perform a leak test for your plant.

1. Close the valve.
2. Slowly apply the test medium to the inlet space upstream of the valve. A sudden surge in pressure and resulting high flow velocities can damage the valve.
3. Open the valve.
4. Apply the required test pressure.
5. Check the valve for leakage to the atmosphere.
6. Depressurize the pipeline section and valve.

## Installation

7. Rework any parts that leak and repeat the leak test.

### 5.4.2 Travel motion

The movement of the actuator stem must be linear and smooth.

- Apply the maximum and minimum control signals to check the end positions of the valve while observing the movement of the actuator stem.
- Check the travel reading at the travel indicator scale.

### 5.4.3 Fail-safe position

- Shut off the signal pressure line.
- Check whether the valve moves to the fail-safe position (see the 'Design and principle of operation' section).

### 5.4.4 Pressure test

The plant operator is responsible for performing the pressure test.



#### Tip

*Our after-sales service can support you to plan and perform a pressure test for your plant.*

---

During the pressure test, make sure the following conditions are met:

- Retract the plug stem to open the valve.
- Observe the maximum permissible pressure for both the valve and plant.

## 6 Start-up

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

### **⚠ WARNING**

#### **Risk of burn injuries due to hot or cold components and pipeline.**

Valve components and the pipeline may become very hot or cold. Risk of burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.
- Wear protective clothing and safety gloves.

### **⚠ WARNING**

#### **Risk of hearing loss or deafness due to loud noise.**

Noise emission (e.g. cavitation or flashing) may occur during operation caused by the process medium and the operating conditions. Additionally, a brief loud noise may occur through the sudden venting of the pneumatic actuator (see 'Fail-safe position') or pneumatic valve accessories not fitted with noise-reducing fittings. Both can damage hearing.

- Wear hearing protection when working near the valve.

### **⚠ WARNING**

#### **Crush hazard arising from actuator and plug stem moving.**

- Do not insert hands or finger into the yoke while the air supply is connected to the actuator.
- Before working on the control valve, disconnect and lock the pneumatic air supply as well as the control signal.
- Do not impede the movement of the actuator and plug stem by inserting objects into the yoke.
- Before unblocking the actuator and plug stem after they have become blocked (e.g. due to seizing up after remaining in the same position for a long time), release any stored energy in the actuator (e.g. spring compression). See associated actuator documentation.

### **⚠ WARNING**

#### **Risk of personal injury due to exhaust air being vented.**

While the valve is operating, air is vented from the actuator, for example, during closed-loop operation or when the valve opens or closes.

- Wear eye protection when working in close proximity to the control valve.

---

### **!** NOTICE

#### ***Risk of contamination of the process medium through high pressure in the steam barrier.***

*A pressure in the steam barrier (steam or sterile fluid) that is higher than the pressure in the valve itself may affect the process medium inside the valve due to it be mixed with the steam (or sterile fluid).*

→ *Observe the relevant hygiene regulations.*

---

Before start-up or putting the valve back into service, make sure the following conditions are met:

- The valve is properly installed into the pipeline (see the 'Installation' section).
- The leak and function tests have been completed successfully (see the 'Testing the installed valve' section).
- The prevailing conditions in the plant section concerned meet the valve sizing requirements (see information under 'Intended use' in the 'Safety instructions and measures' section).

#### **Start-up/putting the valve back into operation**

1. Allow the valve to cool down or warm up to reach ambient temperature before start-up when the ambient temperature and process medium temperature differ greatly or the medium properties require such a measure.
2. Slowly open the shut-off valves in the pipeline. Slowly opening these valves

prevents a sudden surge in pressure and high flow velocities which can damage the valve.

3. Check the valve to ensure it functions properly.

## 7 Operation

Immediately after completing start-up or putting the valve back into operation (see the 'Start-up' section), the valve is ready for use.

### **⚠ WARNING**

**Risk of burn injuries due to hot or cold components and pipeline.**

Valve components and the pipeline may become very hot or cold. Risk of burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.
- Wear protective clothing and safety gloves.

### **⚠ WARNING**

**Risk of personal injury due to pressurized components and process medium being discharged.**

- Do not loosen the screw of the test connection while the valve is pressurized.

### **⚠ WARNING**

**Risk of hearing loss or deafness due to loud noise.**

Noise emission (e.g. cavitation or flashing) may occur during operation caused by the process medium and the operating conditions. Additionally, a loud noise may briefly occur through the sudden venting of the pneumatic actuator or pneumatic valve accessories not fitted with noise-reducing fittings. Both can damage hearing.

- Wear hearing protection when working near the valve.

### **⚠ WARNING**

**Crush hazard arising from actuator and plug stem moving.**

- Do not insert hands or finger into the yoke while the air supply is connected to the actuator.
- Before working on the control valve, disconnect and lock the pneumatic air supply as well as the control signal.
- Do not impede the movement of the actuator and plug stem by inserting objects into the yoke.
- Before unblocking the actuator and plug stem after they have become blocked (e.g. due to seizing up after remaining in the same position for a long time), release any stored energy in the actuator (e.g. spring compression). See associated actuator documentation.

### **⚠ WARNING**

**Risk of personal injury due to exhaust air being vented.**

While the valve is operating, air is vented from the actuator, for example, during closed-loop operation or when the valve opens or closes.

- Wear eye protection when working in close proximity to the control valve.

## Operation

### 7.1 Normal operation

The handwheel of valves with actuators fitted with a handwheel must be in the neutral position during normal operation.

### 7.2 Manual operation

Valves with actuators fitted with a handwheel can be manually closed or opened in case of supply air failure.

### 7.3 CIP (cleaning-in-place)

CIP can be performed with commonly used cleaning fluids.

→ Observe the applicable hygiene regulations.

### 7.4 SIP (sterilization-in-place)

SIP can be performed using steam briefly at a temperature up to 180 °C.

→ Observe the applicable hygiene regulations.

## 8 Malfunctions

Read hazard statements, warnings and caution notes in the 'Safety instructions and measures' section.

### 8.1 Troubleshooting

Malfunction	Possible reasons	Recommended action
Actuator and plug stem does not move on demand.	Actuator is blocked.	Check attachment. Remove the blockage. <b>WARNING!</b> A blocked actuator or plug stem (e.g. due to seizing up after remaining in the same position for a long time) can suddenly start to move uncontrollably. Injury to hands or fingers is possible if they are inserted into the actuator or valve. Before trying to unblock the actuator or plug stem, disconnect and lock the pneumatic air supply as well as the control signal. Before unblocking the actuator, release any stored energy in the actuator (e.g. spring compression). See associated actuator documentation.
	Diaphragm in the actuator defective	See associated actuator documentation.
	Signal pressure too low	Check the signal pressure. Check the signal pressure line for leakage.
Jolting movement of the actuator and plug stem	Lubricant missing	Replace sealing parts (see the 'Servicing' section).
Actuator and plug stem does not stroke through the entire range.	Signal pressure too low	Check the signal pressure. Check the signal pressure line for leakage.
	Travel stop active	See associated actuator documentation.
	Incorrect setting of valve accessories	Check the settings of the valve accessories.
Increased flow through closed valve (seat leakage)	Dirt or other foreign particles deposited between the seat and plug.	Shut off the section of the pipeline and flush the valve.
	The plug is worn.	Replace plug (see the 'Servicing' section) or contact our after-sales service.

## Malfunctions

Malfunction	Possible reasons	Recommended action
The valve leaks to the atmosphere (fugitive emissions).	Seals defective	Replace sealing parts (see the 'Servicing' section).
	Connections loosened	Check connections.

---

### **i** Note

Contact our after-sales service for malfunctions not listed in the table.

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## 8.2 Emergency action

Plant operators are responsible for emergency action to be taken in the plant.

In the event of a valve malfunction:

1. Close the shut-off valves upstream and downstream of the control valve to stop the process medium from flowing through the valve.
2. Perform troubleshooting (see section 8.1).
3. Rectify those malfunctions that can be remedied based on the instructions provided here. Contact our after-sales service in all other cases.

### **Putting the valve back into operation after a malfunction**

See the 'Start-up' section.

## 9 Servicing

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

The following documents are also required for servicing the valve:

- Mounting and operating instructions for the mounted actuator, for example:
  - ► EB 8310-1 for Type 3271 and Type 3277 Pneumatic Actuators with 120 cm<sup>2</sup> actuator area
  - ► EB 8310-4 for Type 3271 and Type 3277 Pneumatic Actuators with 355v2 cm<sup>2</sup> actuator area
  - ► EB 8310-5 for Type 3271 and Type 3277 Pneumatic Actuators with 175v2, 350v2 and 750v2 cm<sup>2</sup> actuator areas
  - ► EB 8310-6 for Type 3271 and Type 3277 Pneumatic Actuators with 240, 350 and 700 cm<sup>2</sup> actuator areas
  - ► EB 8313-1 for Type 3372 Electro-pneumatic Actuator with integrated i/p converter
  - ► EB 8313-3 for Type 3372 Electro-pneumatic Actuator with 120 and 350 cm<sup>2</sup> actuator areas and Type 3725 Positioner
  - ► EB 8315 for Type 3379 Pneumatic Actuator
- ► AB 0100 for tools, tightening torques and lubricant

---

### **⚠ DANGER**

**Risk of bursting due to incorrect opening of pressurized equipment or components.**

*Valves and pipelines are pressure equipment that may burst when handled incorrectly. Flying projectile fragments or the release of process medium under pressure can cause serious injury or even death.*

*Before working on the control valve:*

- ➔ *Depressurize all plant sections affected and the valve (including the actuator). Release any stored energy.*
  - ➔ *Drain the process medium from all the plant sections concerned as well as the valve.*
- 

### **⚠ WARNING**

**Risk of burn injuries due to hot or cold components and pipeline.**

*Valve components and the pipeline may become very hot or cold. Risk of burn injuries.*

- ➔ *Allow components and pipelines to cool down or warm up to the ambient temperature.*
  - ➔ *Wear protective clothing and safety gloves.*
- 

### **⚠ WARNING**

**Risk of hearing loss or deafness due to loud noise.**

*Noise emission (e.g. cavitation or flashing) may occur during operation caused by the process medium and the operating conditions. Additionally, a loud noise may briefly occur through the sudden venting of the*

## Servicing

pneumatic actuator or pneumatic valve accessories not fitted with noise-reducing fittings. Both can damage hearing.

- Wear hearing protection when working near the valve.

---

### **⚠ WARNING**

#### **Crush hazard arising from actuator and plug stem moving.**

- Do not insert hands or finger into the yoke while the air supply is connected to the actuator.
- Before working on the control valve, disconnect and lock the pneumatic air supply as well as the control signal.
- Do not impede the movement of the actuator and plug stem by inserting objects into the yoke.
- Before unblocking the actuator and plug stem after they have become blocked (e.g. due to seizing up after remaining in the same position for a long time), release any stored energy in the actuator (e.g. spring compression). See associated actuator documentation.

---

### **⚠ WARNING**

#### **Risk of personal injury due to exhaust air being vented.**

While the valve is operating, air is vented from the actuator, for example, during closed-loop operation or when the valve opens or closes.

- Wear eye protection when working in close proximity to the control valve.

---

### **⚠ WARNING**

#### **Risk of personal injury due to preloaded springs.**

Actuators with preloaded springs are under tension. They can be identified by the long bolts protruding from the bottom of the actuator.

- Before starting any work on the actuator, relieve the compression from the preloaded springs (see associated actuator documentation).

---

### **⚠ WARNING**

#### **Risk of personal injury due to residual process medium in the valve.**

While working on the valve, residual medium can flow out of the valve and, depending on its properties, cause personal injury, e.g. (chemical) burns.

- Wear protective clothing, safety gloves, respiratory protection and eye protection.

---

### **ⓘ NOTICE**

#### **Risk of the process medium being contaminated through the use of unsuitable lubricants and/or contaminated tools and components.**

- Keep the valve and the tools used free from solvents and grease.
- Make sure that only suitable lubricants are used (▶ AB 0100).

**NOTICE**

**Risk of valve damage due to excessively high or low tightening torques.**

Observe the specified torques when tightening control valve components. Excessive tightening torques lead to parts wearing out more quickly. Parts that are too loose may cause leakage.

→ Observe the specified tightening torques (▶ AB 0100).

**NOTICE**

**Risk of valve damage due to the use of unsuitable tools.**

→ Only use tools approved by SAMSON (▶ AB 0100).

**NOTICE**

**Risk of valve damage due to the use of unsuitable lubricants.**

→ Only use lubricants approved by SAMSON (▶ AB 0100).

**Note**

The control valve was checked by SAMSON before it left the factory.

– Certain test results certified by SAMSON lose their validity when the valve is opened. Such testing includes seat leakage and leak tests.

– The product warranty becomes void if service or repair work not described in these instructions is performed without prior

agreement by SAMSON's After-sales Service.

– Only use original spare parts by SAMSON, which comply with the original specifications.

## 9.1 Periodic testing

Depending on the operating conditions, check the valve at certain intervals to prevent possible failure before it can occur. Plant operators are responsible for drawing up an inspection and test plan.

**Tip**

Our after-sales service can support you in drawing up an inspection and test plan for your plant.

## 9.2 Preparing the valve for service work

1. Lay out the necessary material and tools to have them ready for the service work.
2. Put the control valve out of operation (see the 'Decommissioning' section).
3. Remove the actuator from the valve. See associated actuator documentation.

**Note**

To remove an actuator with "stem extends" fail-safe action and/or with preloaded springs, a certain signal pressure must be applied to the actuator (see associated actuator documentation). Afterwards, the signal

pressure must be removed and the air supply disconnected again and locked.

---

### Tip

We recommend removing the valve from the pipeline before performing any service work (see the 'Removing the valve from the pipeline' section).

---

The following service work can be performed after preparation is completed:

- Replacing the sealing parts and plug (see section 9.4.1)

## 9.3 Installing the valve after service work

1. Mount actuator. See associated actuator documentation.
2. Adjust lower or upper signal bench range. See associated actuator documentation.
3. If the valve has been removed, re-install the valve into the pipeline (see the 'Installation' section).
4. Put the control valve back into operation (see the 'Start-up' section). Observe the requirements and conditions for start-up or putting the valve back into operation.

## 9.4 Service work

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### NOTICE

**Risk of control valve damage due to incorrect servicing.**

Do not perform any service work on versions with a heating jacket.

→ Contact our after-sales service to have service work performed on versions with a heating jacket.

---

→ Before performing any service work, preparations must be made to the control valve (see section 9.2).

→ After all service work is completed, check the control valve before putting it back into operation (see 'Testing the installed valve' in the 'Installation' section).

### 9.4.1 Replacing the sealing parts and plug

See 'Arrangement of the sealing parts in the various versions' on page 9-6 in this section.

---

### NOTICE

**Risk of control valve damage due to incorrect handling.**

Make sure that the plug stem seal is not damaged.

→ The plug must not be moved beyond the valve travel.

---

1. Unscrew the nuts (9 and 10) from the plug stem (2).

2. Depending on the version, unscrew and remove the clamp (34) or bolts (32). Remove the valve bonnet (1) together with plug (2) and, if installed, centering ring (25) including sealing parts.
 

Possible sealing parts:

  - PTFE seal: plug stem seal (3)
  - PEEK seal: plug stem seal (3), centering ring (25) and seal (26)
  - Anti-crystallizing seal: metal centering ring (25) with seal (23) and seal (26)
3. Pull the plug (2) out of the valve bonnet (1). Make sure that the plug stem seal (3) is not damaged.
4. Use a suitable tool to force out damaged parts, e.g. wiper ring (24) and plug stem seal (3).
 

In version with steam barrier, also remove packing (21), washer (17), spring (13) and, if installed, spacer (18 or 41). Clean the packing chamber.
5. Check the surface of the plug stem (2) to ensure it is free of score marks and still has a mirror finish. If the surface has flaws, polish it again to ensure the plug stem seal (3) cannot get damaged.
6. Apply a suitable lubricant to the new parts and plug stem (2).
7. Place the plug stem seal (3) initially in the opposite direction with the lip facing toward the thread end over the plug stem (2) to stretch the lip of the plug stem seal slightly.
8. Carefully pull the plug stem seal (3) off again.
9. Push the new centering ring (25) with sealing parts (depending on version) over the plug stem (2).
10. Carefully slide the plug stem seal (3), centering it, over the thread end of the plug stem (2). The plug stem seal must fit tightly, but slide easily over the plug stem.
11. Insert the plug stem (2) with plug stem seal (3) and centering ring (25) into the valve bonnet (1).
12. Push the wiper ring (24) over the plug stem (2) into the valve bonnet (1).
13. Carefully place the valve bonnet (1) onto the valve body (4).
14. Apply a suitable lubricant to the clamp (34) and the flanges of the valve bonnet (1) and valve body (4).
15. Depending on the version, position clamp (34) and tighten the clamp screws or insert bolts (32) on the valve bonnet (1) and tighten in a crisscross pattern. Observe tightening torques.
16. **Version with clamp:** hit the clamp (34) lightly with a plastic hammer and tighten the clamp screw again.
 

Repeat this procedure several times until all parts fit properly to achieve a leak-tight body.

If the weight of the bonnet (1) in the version with steam barrier is too light to put the clamp back on, slightly compress the

## Servicing

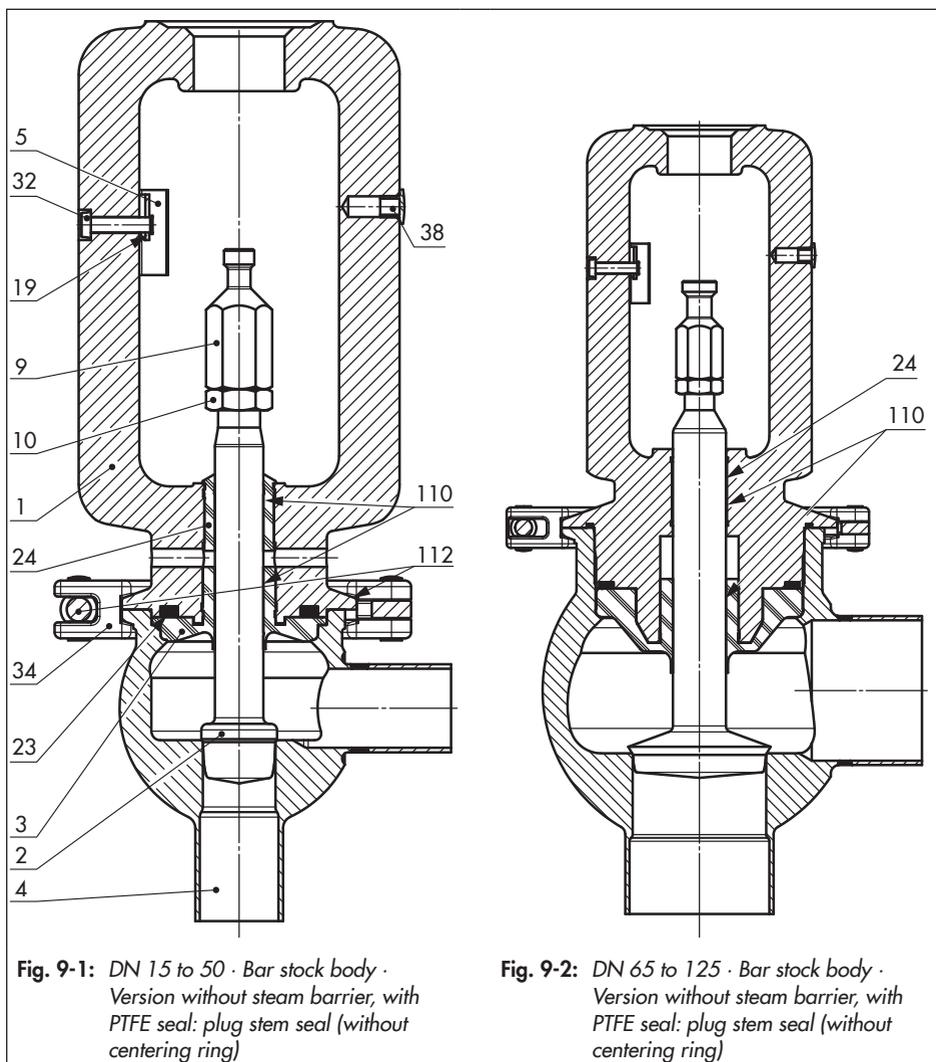
packing springs (13) over the bonnet (1) beforehand.

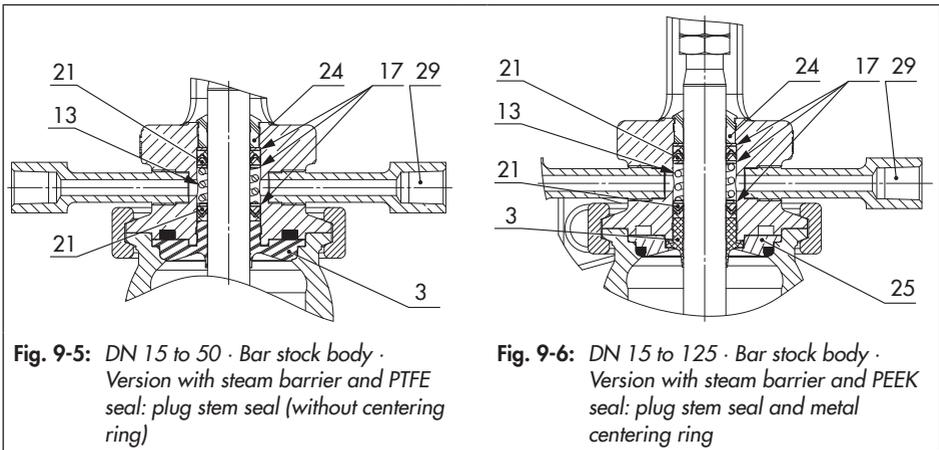
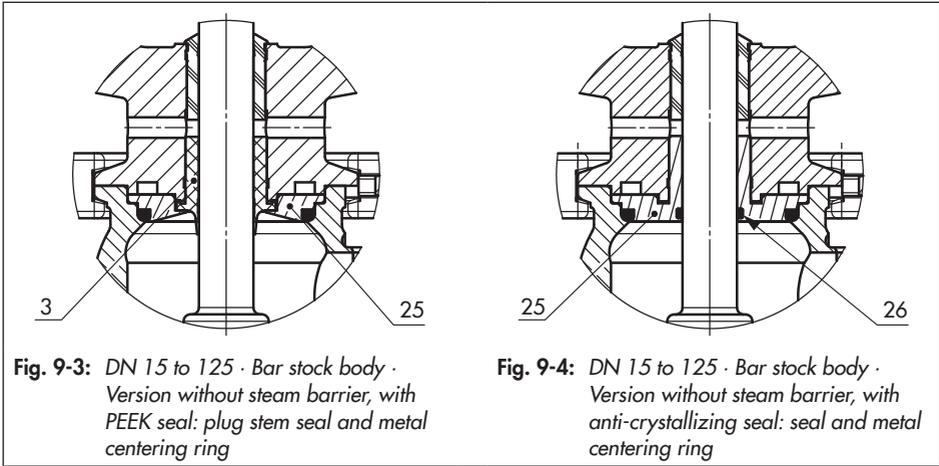
17. Screw the lock nut (10) and stem connector nut (9) onto the plug stem (2).

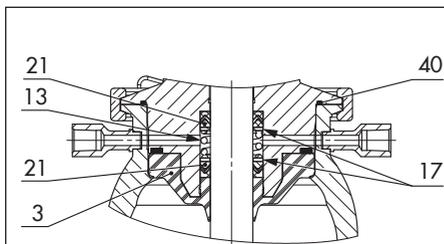
### Arrangement of the sealing parts in the various versions

#### Legend for Fig. 9-1 to Fig. 9-19

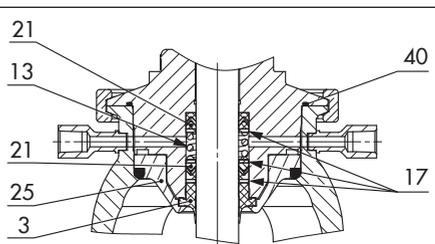
1 Valve bonnet with yoke	23 Seal
2 Plug with plug stem	24 Guide bushing/wiper ring
3 Plug stem seal	25 Centering ring
4 Body	26 Seal
5 Travel indicator scale	29 Grommet/stopper
9 Stem connector nut	32 Screw
10 Lock nut	34 Clamps
13 Spring	38 Blanking plug
17 Washer	40 Seal
18 Spacer	41 Spacer
19 Hanger	110 Lubricant (food-grade grease)
21 V-ring packing	112 Lubricant (food-grade grease)



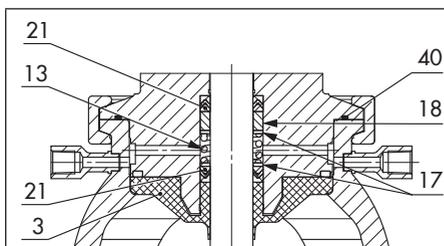




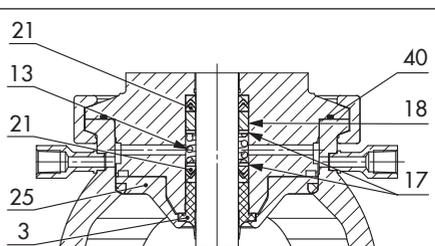
**Fig. 9-7:** DN 65 to 80 · Bar stock body ·  
Version with steam barrier and PTFE  
seal: plug stem seal (without centering  
ring)



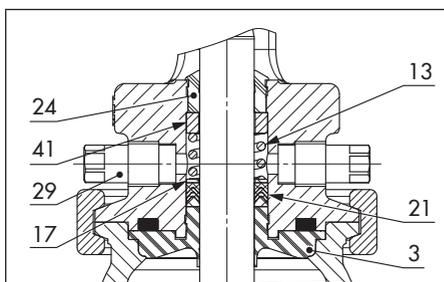
**Fig. 9-8:** DN 65 to 80 · Bar stock body ·  
Version with steam barrier and PEEK  
seal: plug stem seal and metal  
centering ring



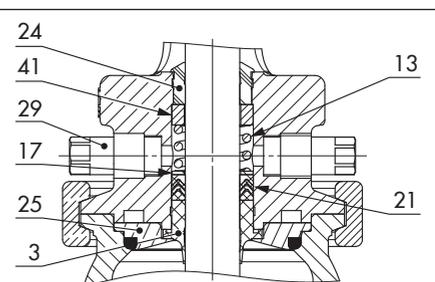
**Fig. 9-9:** DN 100 to 125 · Bar stock body ·  
Version with steam barrier and PTFE  
seal: plug stem seal (without centering  
ring)



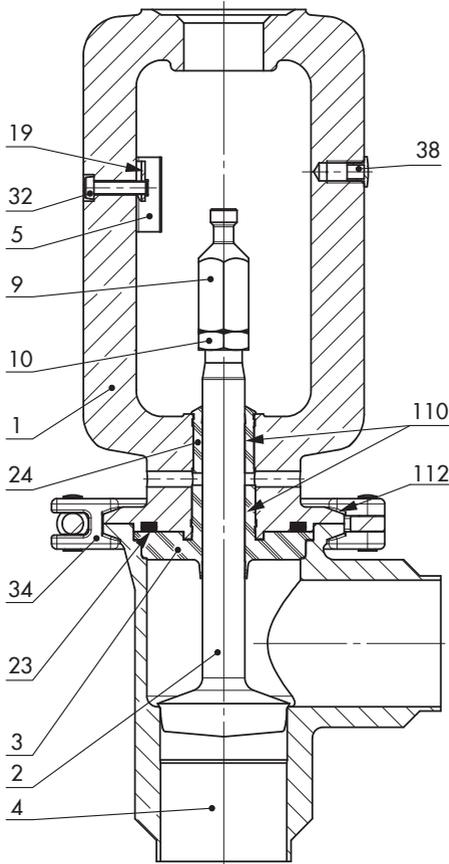
**Fig. 9-10:** DN 100 to 125 · Bar stock body ·  
Version with steam barrier and PEEK  
seal: plug stem seal and metal centering  
ring



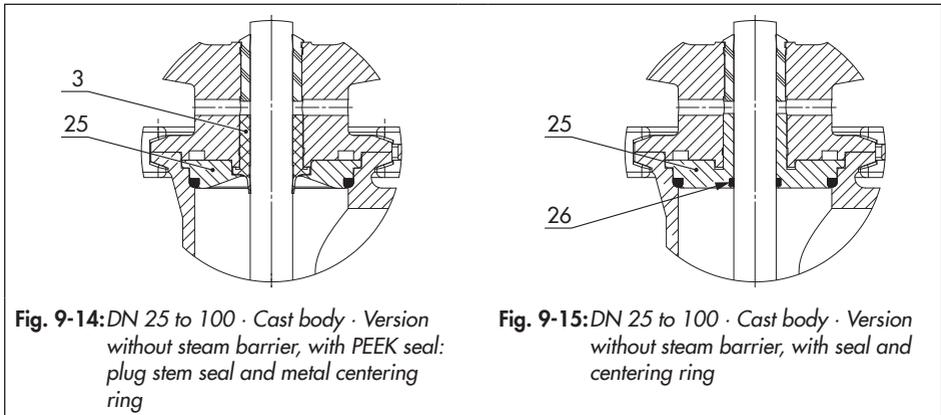
**Fig. 9-11:** DN 15 to 50 · Bar stock body ·  
Version with PTFE packing and  
stopper (without steam barrier), with  
PTFE plug stem seal (without centering  
ring)



**Fig. 9-12:** DN 15 to 50 · Bar stock body ·  
Version with PTFE packing and  
stopper (without steam barrier), with  
PEEK plug stem seal and metal  
centering ring

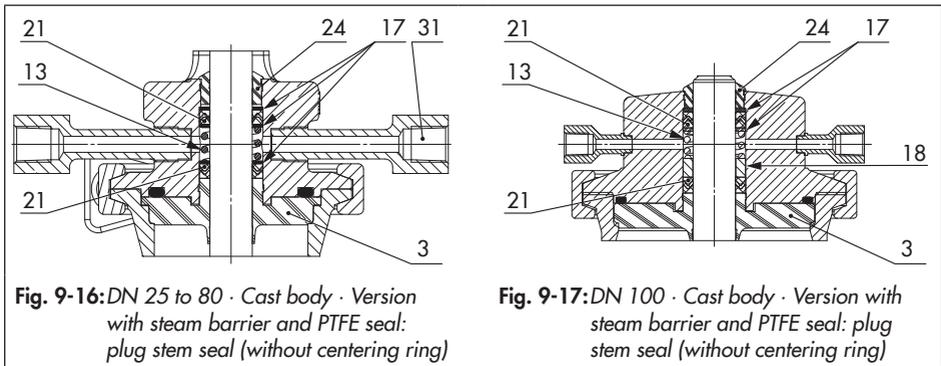


**Fig. 9-13:** DN 25 to 100 · Cast body · Version without steam barrier, with plug stem seal (without centering ring)



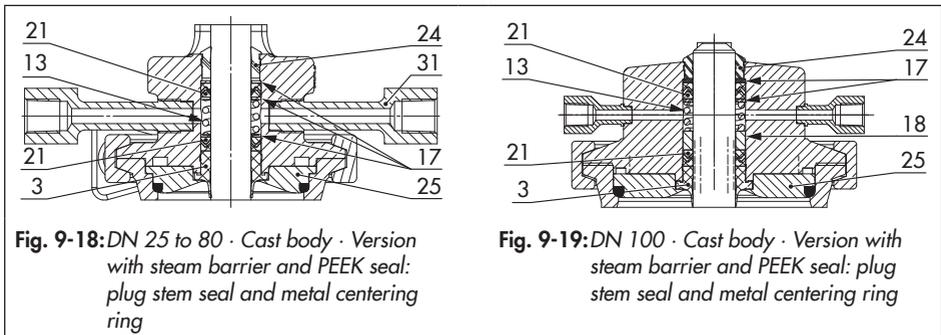
**Fig. 9-14:** DN 25 to 100 · Cast body · Version without steam barrier, with PEEK seal: plug stem seal and metal centering ring

**Fig. 9-15:** DN 25 to 100 · Cast body · Version without steam barrier, with seal and centering ring



**Fig. 9-16:** DN 25 to 80 · Cast body · Version with steam barrier and PTFE seal: plug stem seal (without centering ring)

**Fig. 9-17:** DN 100 · Cast body · Version with steam barrier and PTFE seal: plug stem seal (without centering ring)



**Fig. 9-18:** DN 25 to 80 · Cast body · Version with steam barrier and PEEK seal: plug stem seal and metal centering ring

**Fig. 9-19:** DN 100 · Cast body · Version with steam barrier and PEEK seal: plug stem seal and metal centering ring



## 10 Decommissioning

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

### **⚠ DANGER**

#### **Risk of bursting due to incorrect opening of pressurized equipment or components.**

Valves and pipelines are pressure equipment that may burst when handled incorrectly.

Flying projectile fragments or the release of process medium under pressure can cause serious injury or even death.

Before working on the control valve:

- Depressurize all plant sections affected and the valve (including the actuator). Release any stored energy.
- Drain the process medium from all the plant sections concerned as well as the valve.

### **⚠ WARNING**

#### **Risk of burn injuries due to hot or cold components and pipeline.**

Valve components and the pipeline may become very hot or cold. Risk of burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.
- Wear protective clothing and safety gloves.

### **⚠ WARNING**

#### **Risk of hearing loss or deafness due to loud noise.**

Noise emission (e.g. cavitation or flashing) may occur during operation caused by the process medium and the operating conditions. Additionally, a loud noise may briefly occur through the sudden venting of the pneumatic actuator or pneumatic valve accessories not fitted with noise-reducing fittings. Both can damage hearing.

- Wear hearing protection when working near the valve.

### **⚠ WARNING**

#### **Crush hazard arising from actuator and plug stem moving.**

- Do not insert hands or finger into the yoke while the air supply is connected to the actuator.
- Before working on the control valve, disconnect and lock the pneumatic air supply as well as the control signal.
- Do not impede the movement of the actuator and plug stem by inserting objects into the yoke.
- Before unblocking the actuator and plug stem after they have become blocked (e.g. due to seizing up after remaining in the same position for a long time), release any stored energy in the actuator (e.g. spring compression). See associated actuator documentation.

## Decommissioning

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### **⚠ WARNING**

#### ***Risk of personal injury due to exhaust air being vented.***

*While the valve is operating, air is vented from the actuator, for example, during closed-loop operation or when the valve opens or closes.*

➔ *Wear eye protection when working in close proximity to the control valve.*

---

### **⚠ WARNING**

#### ***Risk of personal injury due to residual process medium in the valve.***

*While working on the valve, residual medium can flow out of the valve and, depending on its properties, cause personal injury, e.g. (chemical) burns.*

➔ *Wear protective clothing, safety gloves, respiratory protection and eye protection.*

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To decommission the control valve for service work or to remove it from the pipeline, proceed as follows:

1. Close the shut-off valves upstream and downstream of the control valve to stop the process medium from flowing through the valve.
2. Completely drain the pipelines and valve.
3. Disconnect and lock the pneumatic air supply to depressurize the actuator.
4. Release any stored energy.

5. If necessary, allow the pipeline and valve components to cool down or warm up to the ambient temperature.

## 11 Removal

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

### **⚠ WARNING**

#### **Risk of burn injuries due to hot or cold components and pipeline.**

Valve components and the pipeline may become very hot or cold. Risk of burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.
- Wear protective clothing and safety gloves.

### **⚠ WARNING**

#### **Crush hazard arising from actuator and plug stem moving.**

- Do not insert hands or finger into the yoke while the air supply is connected to the actuator.
- Before working on the control valve, disconnect and lock the pneumatic air supply as well as the control signal.
- Do not impede the movement of the actuator and plug stem by inserting objects into the yoke.
- Before unblocking the actuator and plug stem after they have become blocked (e.g. due to seizing up after remaining in the same position for a long time), release any stored energy in the actuator (e.g. spring compression). See associated actuator documentation.

### **⚠ WARNING**

#### **Risk of personal injury due to residual process medium in the valve.**

While working on the valve, residual medium can flow out of the valve and, depending on its properties, cause personal injury, e.g. (chemical) burns.

- Wear protective clothing, safety gloves, respiratory protection and eye protection.

### **⚠ WARNING**

#### **Risk of personal injury due to preloaded springs.**

Actuators with preloaded springs are under tension. They can be identified by the long bolts protruding from the bottom of the actuator.

- Before starting any work on the actuator, relieve the compression from the preloaded springs.

Before removing the valve, make sure the following conditions are met:

- The control valve is put out of operation (see the 'Decommissioning' section).

### 11.1 Removing the valve from the pipeline

#### a) Version with welding ends

1. Support the valve to hold it in place when separated from the pipeline (see the 'Shipment and on-site transport' section).
2. Cut the pipeline in front of the weld seam.
3. Remove the valve from the pipeline (see the 'Shipment and on-site transport' section).

#### a) Valve with flanges, threaded ends or clamp connections:

1. Support the valve to hold it in place when separated from the pipeline (see the 'Shipment and on-site transport' section).
2. Undo flanged, threaded or clamp connection.
3. Remove the valve from the pipeline (see the 'Shipment and on-site transport' section).

### 11.2 Removing the actuator from the valve

See associated actuator documentation.

## 12 Repairs

If the valve does not function properly according to how it was originally sized or does not function at all, it is defective and must be repaired or exchanged.

### ! NOTICE

**Risk of valve damage due to incorrect service or repair work.**

- Do not perform any repair work on your own.
- Contact SAMSON's After-sales Service for repair work.

**After checking your registration, we will send you a return merchandise authorization (RMA).**

3. Attach the RMA (together with the Declaration on Decontamination) to the outside of your shipment so that the documents are clearly visible.
4. Send the shipment to the address given on the RMA.

### i Note

Further information on returned devices and how they are handled can be found at  
 ► [www.samsongroup.com](http://www.samsongroup.com) > Service & Support > After-sales Service.

### 12.1 Returning devices to SAMSON

Defective devices can be returned to SAMSON for repair.

Proceed as follows to return devices:

1. Exceptions apply concerning some special device models ► [www.samsongroup.com](http://www.samsongroup.com) > Service & Support > After-sales Service.
2. Send an e-mail ► [retouren@samsongroup.com](mailto:retouren@samsongroup.com) to register the return shipment including the following information:
  - Type
  - Article no.
  - Configuration ID
  - Original order
  - Completed Declaration on Contamination, which can be downloaded from our website at  
 ► [www.samsongroup.com](http://www.samsongroup.com) > Service & Support > After-sales Service.



## 13 Disposal

- Observe local, national and international refuse regulations.
- Do not dispose of components, lubricants and hazardous substances together with your household waste.



## 14 Certificates

The declarations and certificates are included on the next pages:

- Declaration of conformity in compliance with Pressure Equipment Directive 2014/68/EU on pages 14-2 to 14-5
- Declaration of conformity according to Machinery Directive 2006/42/EC on page 14-6
- Declaration of conformity in compliance with Regulations (EC) No. 1935/2004 and (EU) No. 10/2011 on pages 14-7 to 14-10
- RoHS declaration of conformity in compliance with Directive 2011/65/EU, 2015/863/EU on page 14-11
- Declaration of conformity in compliance with Regulations GB 4806.1-2016 and GB 31603-2015 of the Chinese food industry on pages 14-12 to 14-14
- Declaration of conformity in compliance with the requirements in TSG D7002-2006 for Chinese pressure equipment on page 14-15
- Declaration of conformity according to Regulation China RoHS 2.0, GB/T26572-2011 on page 14-16
- 3-A certificate (standard 53-06) on page 14-17
- EHEDG certificate EL Class I on pages 14-18 to 14-20

The certificates shown were up to date at the time of publishing. The latest certificates can be found on our website:

► [www.samsongroup.com](http://www.samsongroup.com) > *Products & Applications* > *Product selector* > *Valves* > 3347

Other optional certificates are available on request.



## DECLARATION UE DE CONFORMITE EU DECLARATION OF CONFORMITY EU-KONFORMITÄTSEKTLÄRUNG

1/2

DC014  
2020-02

### Module A / Modul A

Par la présente, SAMSON REGULATION SAS déclare sous sa seule responsabilité pour les produits suivants :  
For the following products, SAMSON REGULATION SAS hereby declares under its sole responsibility:  
SAMSON REGULATION SAS erklärt in alleiniger Verantwortung für folgende Produkte:

Appareils / Devices / Geräte	Type / Typ	Exécution / Version / Ausführung
Vanne de décharge / back pressure reducing valve / Überströmventil	2371-0	DIN & ANSI - corps en acier forgé / body of forged steel / Gehäuse Schmiedestahl DN 32 – 100 P <sub>max</sub> T = 20°C 10 bar NPS 1 1/4 – 4 P <sub>max</sub> T = 70°F 150 psi Tous fluides / all fluids / alle Fluide
Détendeur alimentaire / pressure reducing valve / Druckminderventil	2371-1	DIN - corps en fonte grise / body of cast iron / Gehäuse Grauguss: GJL-250 DN 65 – 150 PN16 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
Vanne de régulation passage droit / globe valve / Durchgangsventil	3241	DIN - corps en fonte sphéroïdale / body of spheroidal graphite iron / Gehäuse Sphäroguss : GJS-400-18-LT DN 50 PN25 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3241	ANSI - corps en fonte grise / body of cast iron / Gehäuse Grauguss: A126 B Cl 250 NPS 1 1/2 – 3 ; Cl 125 NPS 2 1/2 – 6 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3244	DIN - corps en fonte grise / body of cast iron / Gehäuse Grauguss: GJL-250 DN 65 – 150 PN16 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
Vanne de régulation 3 voies / 3-way Valve / Drei-Wege-Stellventil	3244	DIN - corps en fonte sphéroïdale / body of spheroidal graphite iron / Gehäuse Sphäroguss : GJS-400-18-LT DN 50 PN25 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3249	DIN & ANSI - corps en acier forgé / body of forged steel / Gehäuse Schmiedestahl DN 32 – 100 P <sub>max</sub> T = 20°C 10 bar NPS 1 1/4 – 4 P <sub>max</sub> T = 70°F 150 psi Tous fluides / all fluids / alle Fluide
Vanne aseptique / Aseptic valve / Aseptisches Ventil	3321	DIN - corps en fonte grise / body of cast iron / Gehäuse Grauguss: GJL-250 DN 65 – 100 PN16 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3321	ANSI - corps en fonte grise / body of cast iron / Gehäuse Grauguss: A126 B Cl 125 NPS 2 1/2 – 4 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
Vanne de régulation 3 voies / 3-way Valve / Drei-Wege-Stellventil	3323	DIN - corps en fonte grise / body of cast iron / Gehäuse Grauguss: GJL-250 DN 65 – 100 PN16 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3323	ANSI - corps en fonte grise / body of cast iron / Gehäuse Grauguss: A126 B Cl 125 NPS 2 1/2 – 4 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
Vanne à membrane / Diaphragm valve / Membran-Ventil	3345	DIN & ANSI corps en fonte sphéroïdale, aciers moulé & forgé / body of spheroidal graphite iron, cast & forged steel / Gehäuse Sphäroguss, Gusstahl & Schmiedestahl DN 32 – 100 NPS <sup>1)2)4)</sup> Tous fluides / all fluids / alle Fluide
Vanne alimentaire / Sanitary valve / Hygienisches Ventil	3347	DIN & ANSI corps en aciers moulé & forgé / body of, cast & forged steel / Gehäuse Gusstahl & Schmiedestahl DN 65 – 125 P <sub>max</sub> T = 20°C 16 bar NPS 2 1/2 – 5 P <sub>max</sub> T = 70°F 240 psi Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
Vanne aseptique / Aseptic valve / Aseptisches Ventil	3349	DIN & ANSI - corps en acier forgé / body of forged steel / Gehäuse Schmiedestahl DN 32 – 100 P <sub>max</sub> T = 20°C 10 bar NPS 1 1/4 – 4 P <sub>max</sub> T = 70°F 150 psi Tous fluides / all fluids / alle Fluide
	3351	DIN - corps en fonte grise / body of cast iron / Gehäuse Grauguss: GJL-250 DN 65 – 150 PN16 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
Vanne Tout ou Rien / On-Off Valve / Auf-Zu Ventil	3351	DIN - corps en fonte sphéroïdale / body of spheroidal graphite iron / Gehäuse Sphäroguss : GJS-400-18-LT DN 50 PN25 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3351	ANSI - corps en fonte grise / body of cast iron / Gehäuse Grauguss: A126 B Cl 250 NPS 1 1/2 – 3 ; Cl 125 NPS 2 1/2 – 6 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	5090	DIN & ANSI - corps en acier forgé / body of forged steel / Gehäuse Schmiedestahl DN 40 – 500 NPS 1.5 – 20
Tube de mesure / Measure tube / Messrohr	5091	DIN & ANSI - corps en acier forgé / body of forged steel / Gehäuse Schmiedestahl DN 40 – 500 NPS 1.5 – 20

<sup>1)</sup> Gas selon l'article 4 § 1 c) i) / Gases Acc. to article 4 paragraphs 1 c) i) / Gases nach Artikel 4 Abs. 1 Pkt. c) i)  
<sup>2)</sup> Liquide selon l'article 4 § 1 c) ii) / Liquids Acc. to article 4 paragraphs 1 c) ii) / Flüssigkeiten nach Artikel 4 Abs. 1 Pkt. c) ii)

Agrément en cours d'examen par Bureau Veritas Exploitation / Approval being examined by Bureau Veritas Exploitation / Genehmigung wird von Bureau Veritas Exploitation geprüft.



## DECLARATION UE DE CONFORMITE EU DECLARATION OF CONFORMITY EU-KONFORMITÄTSERKLÄRUNG

2/2

Module A / Modul A

DC014  
2020-02

la conformité avec le règlement suivant : / the conformity with the following requirement: / die Konformität mit nachfolgender Anforderung:

La Directive du Parlement Européen et du Conseil d'harmonisation des lois des Etats Membres concernant la mise à disposition sur le marché d'équipements sous pression / Directive of the European Parliament and of the Council on the Harmonization of the laws of the Member States relating to the making available on the market of pressure equipment / Richtlinie des Europäischen Parlaments und des Rates zur Harmonisierung der Rechtsvorschriften der Mitgliedstaaten über die Bereitstellung von Druckgeräten auf dem Markt	2014/68/UE 2014/68/EU	Du / of / vom 15.05.2014
Procédure d'évaluation de la conformité appliquée pour les fluides selon l'Article 4 § 1 Applied conformity assessment procedure for fluids according to Article 4 (1) Angewandtes Konformitätsbewertungsverfahren für Fluide nach Art. 4 Abs.1	Module A / Modul A	

Normes techniques appliquées / Technical standards applied / Angewandte technische Spezifikation :  
DIN EN 12516-2, DIN EN 12516-3, ASME B16.34, DIN-EN 60534-4, DIN-EN 1092-1

Fabricant / manufacturer / Hersteller : Samson Régulation SAS, 1, rue Jean Corona, FR-69120 VAULX-EN-VELIN

Vaulx-en-Velin, le 07/02/20

Bruno Soulas  
Directeur Administratif / Head of Administration

Joséphine Signoles-Fontaine  
Responsable QSE / QSE Manager



## DECLARATION UE DE CONFORMITE EU DECLARATION OF CONFORMITY EU-KONFORMITÄTSERKLÄRUNG

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DC012  
2020-11

### Module H / Modul H, N°/ Nr CE-0062-PED-H-SAM 001-20-FRA-rev-A

Par la présente, SAMSON REGULATION SAS déclare sous sa seule responsabilité pour les produits suivants :  
For the following products, SAMSON REGULATION SAS hereby declares under its sole responsibility:  
SAMSON REGULATION SAS erklärt in alleiniger Verantwortung für folgende Produkte:

Appareils / Devices / Geräte	Type / Typ	Exécution / Version / Ausführung
Vanne de régulation passage droit / globe valve / Durchgangsventil	3241	DIN - corps en fonte sphéroïdale / body of spheroidal graphite iron / Gehäuse Sphäroguss : GJS-400-18-LT DN 65 - 150 PN 25 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3241	ANSI - corps en fonte grise / body of cast iron / Gehäuse Grauguss: A126 B Cl 250 NPS 4 - 6 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3241	DIN ANSI - corps en acier moulé / body of cast steel / Gehäuse Gussstahl DN 32 - 150 PN <sub>max</sub> 40 NPS <sup>1)2</sup> - 6 Cl <sub>max</sub> 300 Tous fluides / all fluids / alle Fluide
Vanne de régulation 3 voies / 3-way Valve / Drei-Wege-Stellventil	3244	DIN - corps en fonte sphéroïdale / body of spheroidal graphite iron / Gehäuse Sphäroguss : GJS-400-18-LT DN 65 - 150 PN 25 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3244	DIN ANSI - corps en acier moulé / body of cast steel / Gehäuse Gussstahl DN 32 - 150 PN <sub>max</sub> 40 NPS <sup>1)2</sup> - 6 Cl <sub>max</sub> 300 Tous fluides / all fluids / alle Fluide
Vanne de régulation passage droit / globe valve / Durchgangsventil	3251	DIN & ANSI - corps en acier moulé / body of cast steel / Gehäuse Gussstahl DN 32 - 200 NPS 1 1/2 - 8. Tous fluides / all fluids / alle Fluide
	3252	DIN & ANSI - corps en acier forgé / body of forged steel / Gehäuse Schmiedestahl DN 32 - 80 PN <sub>max</sub> 400 NPS 1 1/2 - 3 Cl <sub>max</sub> 2500 Tous fluides / all fluids / alle Fluide
Vanne haute pression / High pressure valve / Hochdruckventil	3252	DIN - corps en acier forgé / body of forged steel / Gehäuse Schmiedestahl DN 100 PN <sub>max</sub> 16 Tous fluides / all fluids / alle Fluide
	3252	DIN & ANSI - corps en acier moulé / body of cast steel / Gehäuse Gussstahl DN 32 - 200 NPS 1 1/2 - 8. Tous fluides / all fluids / alle Fluide
Vanne équerre / Angle valve / Eckventil	3256	DIN & ANSI - corps en acier moulé / body of cast steel / Gehäuse Gussstahl DN 32 - 200 NPS 1 1/2 - 8. Tous fluides / all fluids / alle Fluide
Vanne à segment sphérique / Segment ball valve / Kugelsegmentventil	3310	DIN & ANSI - corps en acier moulé / body of cast steel / Gehäuse Gussstahl DN 40 - 300 NPS 1 1/2 - 12. Tous fluides / all fluids / alle Fluide
Vanne de régulation passage droit / globe valve / Durchgangsventil	3321	DIN ANSI - corps en acier moulé / body of cast steel / Gehäuse Gussstahl DN 32 - 100 Cl 150 - 300 NPS <sup>1)2</sup> - 4. Tous fluides / all fluids / alle Fluide
Vanne papillon / Butterfly valve / Stellklappe	3331	DIN ANSI - corps en acier moulé / body of cast steel / Gehäuse Gussstahl DN 50 - 400 NPS 2 - 16 Tous fluides / all fluids / alle Fluide
Vanne à membrane / Diaphragm valve / Membran-Ventil	3345	DIN & ANSI corps en fonte sphéroïdale, aciers moulé & forgé / body of spheroidal graphite iron, cast & forged steel / Gehäuse Sphäroguss, Gussstahl & Schmiedestahl DN 125 - 150 NPS 5 - 6 Tous fluides / all fluids / alle Fluide
Vanne alimentaire / Sanitary valve / Hygienisches Ventil	3347	DIN & ANSI corps en aciers moulé & forgé / body of, cast & forged steel / Gehäuse Gussstahl & Schmiedestahl DN 150 P <sub>max</sub> T = 20°C 16 bar NPS 6 P <sub>max</sub> T = 70°C 240 psi. Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3347	DIN & ANSI corps en aciers moulé & forgé / body of, cast & forged steel / Gehäuse Gussstahl & Schmiedestahl DN 32 - 150 P <sub>max</sub> T = 20°C 40 bar NPS 1 1/2 - 6 P <sub>max</sub> T = 70°F 600 psi Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3347	DIN & ANSI corps en aciers moulé & forgé / body of, cast & forged steel / Gehäuse Gussstahl & Schmiedestahl DN 32 - 125 P <sub>max</sub> T = 20°C 63 bar NPS 1 1/2 - 5 P <sub>max</sub> T = 70°F 945 psi Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
Vanne Tout ou Rien / On-Off Valve / Auf-Zu Ventil	3351	DIN - corps en fonte sphéroïdale / body of spheroidal graphite iron / Gehäuse Sphäroguss : GJS-400-18-LT DN 65 - 150 PN 25 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3351	ANSI - corps en fonte grise / body of cast iron / Gehäuse Grauguss: A126 B Cl 250 NPS 4 - 6 Fluides / fluids / Fluide G2, L1, L2 <sup>1)</sup>
	3351	DIN ANSI - corps en acier moulé / body of cast steel / Gehäuse Gussstahl DN 32 - 150 PN <sub>max</sub> 40 NPS <sup>1)2</sup> - 6 Cl <sub>max</sub> 300 Tous fluides / all fluids / alle Fluide
Bride de mesure / Measure flange / Messflansch	5090	DIN & ANSI - corps en acier forgé / body of forged steel / Gehäuse Schmiedestahl DN 40 - 500 NPS 1.5 - 20
Tube de mesure / Measure tube / Messrohr	5091	DIN & ANSI - corps en acier forgé / body of forged steel / Gehäuse Schmiedestahl DN 40 - 500 NPS 1.5 - 20

<sup>1)</sup> Gas selon l'article 4 § 1.c) i) / Gases Acc. to article 4 paragraphs 1.c) i) / Gases nach Artikel 4 Abs. 1 Pkt. c) i)  
Liquide selon l'article 4 § 1.c) ii) / Liquids Acc. to article 4 paragraphs 1.c) ii) / Flüssigkeiten nach Artikel 4 Abs. 1 Pkt. c) ii)



**DECLARATION UE DE CONFORMITE  
EU DECLARATION OF CONFORMITY  
EU-KONFORMITÄTSERKLÄRUNG**

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**Module H / Modul H, N°/ Nr CE-0062-PED-H-SAM 001-20-FRA-rev-A**

**DC012  
2020-11**

la conformité avec le règlement suivant : / the conformity with the following requirement: / die Konformität mit nachfolgender Anforderung:

<p>La Directive du Parlement Européen et du Conseil d'harmonisation des lois des Etats Membres concernant la mise à disposition sur le marché d'équipements sous pression / Directive of the European Parliament and of the Council on the Harmonization of the laws of the Member States relating of the making available on the market of pressure equipment / Richtlinie des Europäischen Parlaments und des Rates zur Harmonisierung der Rechtsvorschriften der Mitgliedstaaten über die Bereitstellung von Druckgeräten auf dem Markt</p>	<p>2014/68/UE 2014/68/EU</p>	<p>Du / of / vom 15.05.2014</p>
<p>Procédure d'évaluation de la conformité appliquée pour les fluides selon l'Article 4 § 1 Applied conformity assessment procedure for fluids according to Article 4 (1) Angewandtes Konformitätsbewertungsverfahren für Fluide nach Art. 4 Abs.1</p>	<p>Module H / Modul H</p>	<p>certificat n° / Zertifikat-Nr. CE-0062-PED-H- SAM 001-20-FRA- rev-A</p>

**Normes techniques appliquées / Technical standards applied / Angewandte technische Spezifikation :**  
DIN EN 12516-2, DIN EN 12516-3, ASME B16.34, DIN-EN 60534-4, DIN-EN 1092-1

Le système de contrôle Qualité du fabricant est effectué par l'organisme de certification suivant :  
The manufacturer's quality management system is monitored by the following notified body:  
Das Qualitätssicherungssystem des Herstellers wird von folgender benannter Stelle überwacht:

**Bureau Veritas Services SAS N°/Nr 0062, 8 Cours du Triangle, 92800 PUTEAUX - LA DEFENSE**  
**Fabricant / manufacturer / Hersteller : Samson Régulation SAS, 1, rue Jean Corona, FR-69120 VAULX-EN-VELIN**

Vaulx-en-Velin, le 20/11/20

Bruno Soulas  
Directeur Administratif / Head of Administration

Joséphine Signoles-Fontaine  
Responsable QSE / QSE Manager



## EU DECLARATION OF CONFORMITY

DC032  
2020-07

### Declaration of Conformity of Final Machinery

in accordance with Annex II, section 1. A. of the Directive 2006/42/EC

For the following products:

#### **Pneumatic Control & Hygienic Angle Valve Type 3347-1/-7 consisting of the type 3347 Valve and Type 3271/Type 3277 Pneumatic Actuator or Type 3347 with Type 3379 or 3372 Pneumatic Actuator**

We hereby declare that the machinery mentioned above complies with all applicable requirements stipulated in Machinery Directive 2006/42/EC.

For product descriptions of the valve and actuator, refer to:

- Type 3347 Valve: Mounting and Operating Instructions EB 8097
- Types 3271 and 3277 Actuators: Mounting and Operating Instructions EB 8310-X
- Type 3379 Actuator: Mounting and Operating Instructions EB 8315
- Type 3372 Actuator: Mounting and Operating Instructions EB 8313

Valve accessories (e.g. positioners, limit switches, solenoid valves, lock-up valves, supply pressure regulators, volume boosters and quick exhaust valves) are classified as machinery components in this declaration of conformity and do not fall within the scope of the Machinery Directive as specified in § 35 and § 46 of the Guide to Application of the Machinery Directive 2006/42/EC issued by the European Commission. In the SAMSON Manual H 02 titled "Appropriate Machinery Components for SAMSON Pneumatic Control Valves with a Declaration of Conformity of Final Machinery", SAMSON defines the specifications and properties of appropriate machinery components that can be mounted onto the above specified final machinery.

Referenced technical standards and/or specifications:

- VCI, VDMA, VGB: "Leitfaden Maschinenrichtlinie (2006/42/EG) — Bedeutung für Armaturen, Mai 2018" [German only]
- VCI, VDMA, VGB: "Zusatzdokument zum „Leitfaden Maschinenrichtlinie (2006/42/EG) — Bedeutung für Armaturen vom Mai 2018" [German only], based on DIN EN ISO 12100:201 1-03

Comment:

Information on residual risks of the machinery can be found in the mounting and operating instructions of the valve and actuator as well as in the referenced documents listed in the mounting and operating instructions.

Persons authorized to compile the technical file:

SAMSON REGULATION SAS – 1 rue Jean Corona – FR-69120 VAULX-EN-VELIN  
Vaux-en-Velin, 30 July 2020

Michael Lachenal-Chevallet  
R&D Manager

Joséphine Signoles-Fontaine  
QSE Manager



## **EU DECLARATION OF CONFORMITY**

For the following product

**DC006**

**2018-01**

### **Type 3347 Hygienic Angle Valve**

The Type 3347 Hygienic Angle Valve meets the requirements of the food industries according to the following parameters.

The valve meets the requirements of Regulations (EC) No. 1935/2004 and (EU) No. 10/2011. The seals underwent overall and specific migration testing whose conditions and results are listed on the next page.

The composition of the PTFE TFM 1705 granules used in the manufacture of the seals, in direct contact with the fluid, comply with :

- the Regulation (EC) No. 1935/2004 on materials and articles intended to come into contact with food,
- the Regulation (EC) No. 2023/2006 on good manufacturing practice for materials and articles intended to come into contact with food,
- the Regulation (EU) No. 10/2011 on plastic materials and articles intended to come into contact with food,



### Overall migration (OM)

The maximum limit on the migration has been tested and measured in accordance with the following table:

Test conditions	Food simulant	Duration	Temperature	Maximum limit on the migration (mg/dm <sup>2</sup> )	Migration results (mg/dm <sup>2</sup> )	Surface to volume ratio (dm <sup>2</sup> /dl)
			Tests			
MG 5	A : 10% ethanol	2 h	100°C	10	4.4	1
MG 5	B : 3% acetic acid	2 h	100°C	10	3.1	1
MG 5	D2 : Oil	2 h	100°C	10	1.4	1

### Specific migration (SM)

The maximum limit on the specific migration of substances authorized by the Regulation (EU) No. 10/2011 Annex I has been tested and measured in accordance with the following table:

Monomeres	FCM N°	CAS N°	SML (mg/kg)	Status
TFE = tetrafluoroethylene	281	116-14-3	0.05	OK
PPVE = Perfluoropropylvinyl Ether	423	1623-05-8	0.05	OK
hexafluoropropylene	282	116-15-4	0.01	OK

The migration tests such as defined in the **Regulation (EU) No. 10/2011** and performed under the conditions above lead to the conclusions that the seals can be used:

- for all foods such as specified in the Annex III Table 2 & §4 due to satisfactory results obtained with food simulants A, B & D2 (Annex III table 1).
- under test conditions: high temperature applications up to 121°C (cf. Annex V Chapter 3 Table 3).

SAMSON REGULATION S.A.S

Vaulx-en-Velin, 24/01/2018

Bruno Soulas  
Head of Administration

Joséphine Signoles-Fontaine  
QSE Manager



## EU DECLARATION OF CONFORMITY

For the following product

**DC020**

**2019-09**

### **PEEK seals for types 3249 / 3347 / 3349**

The PEEK seals used for soft sealings meet the requirements of the food industries according to the following parameters.

They meet the requirements of Regulations (EC) No. 1935/2004 and (EU) No. 10/2011. The seals underwent overall and specific migration testing whose conditions and results are listed on the next page.

The composition of VICTREX 450G granules used in the manufacture of seals and in direct contact with fluid comply with :

- the Regulation (EC) No. 1935/2004 on materials and articles intended to come into contact with food,
- the Regulation (EC) No. 2023/2006 on good manufacturing practice for materials and articles intended to come into contact with food,
- the Regulation (EU) No. 10/2011 on plastic materials and articles intended to come into contact with food,



### Overall migration (OM)

The maximum limit on the migration has been tested and measured in accordance with the following table:

Test conditions	Food simulant	Duration	Temperature	Maximum limit on the migration (mg/dm <sup>2</sup> )	Migration results (mg/dm <sup>2</sup> )	Surface to volume ratio (dm <sup>2</sup> /dl)
			Tests			
MG 5	A : 10% ethanol	2 h	100°C	10	6.7	1
MG 5	B : 3% acetic acid	2 h	100°C	10	1.6	1
MG 5	D2 : Oil	2 h	100°C	10	2.1	1

### Specific migration (SM)

The maximum limit on the specific migration of substances authorized by the Regulation (EU) No. 10/2011 Annex I has been tested and measured in accordance with the following table:

Monomeres	FCM N°	CAS N°	SML (mg/kg)	Status
4.4-difluorobenzophenone	337	345-92-6	0.05	OK
Hydroquinone or 1.4 dihydroxybenzen	295	123-31-9	0.6	OK
Diphenyl sulfone	313	127-63-9	3	OK

The migration tests such as defined in **the Regulation (EU) No. 10/2011** and performed under the conditions above lead to the conclusions that the seals can be used:

- for all foods such as specified in the Annex III Table 2 & §4 due to satisfactory results obtained with food simulants A, B & D2 (Annex III table 1).
- under test conditions: high temperature applications up to 121°C (cf. Annex V Chapter 3 Table 3).

SAMSON REGULATION S.A.S.

Bruno Soulas  
Head of Administration

SAMSON REGULATION S.A.S.

Joséphine Signoles-Fontaine  
QSE Manager

# SAMSON REGULATION S.A.S.



1/1

**DC008**  
**2019-11**

**DECLARATION UE DE CONFORMITE**  
**EU DECLARATION OF CONFORMITY**  
**EU KONFORMITÄTSERKLÄRUNG**

La présente déclaration de conformité est établie sous la seule responsabilité du fabricant.  
This declaration of conformity is issued under the sole responsibility of the manufacturer.  
Die alleinige Verantwortung für die Ausstellung dieser Konformitätserklärung trägt der Hersteller.

Nous certifions pour les produits suivants en exécution standard :

For the following products in standard execution:

Für die folgenden Produkte in Standard-Ausführung:

Type / type / Typ : 2371, 3249, 3252, 3310, 3331, 3347, 3349, 3351, 3710, 3711, 3776, 3777, 3812,  
3963, 3964, 3967, 4708, 4746, 5090, Samstation

sont conformes à la législation applicable harmonisée de l'Union :  
the conformity with the relevant Union harmonization legislation is declared with:  
wird die Konformität mit den einschlägigen Harmonisierungsrechtsvorschriften der Union bestätigt:

**RoHS 2011/65/EU, 2015/863/EU**

**EN50581:2012-09**

Fabricant : SAMSON REGULATION S.A.S.  
Manufacturer: 1, rue Jean Corona  
Hersteller: 69520 Vaulx-en-Velin  
France

Vaulx-en-Velin, le 26/11/19

Au nom du fabricant,  
On behalf of the Manufacturer,  
Im Namen des Herstellers,

SAMSON REGULATION S.A.S.

Joséphine SIGNOLES-FONTAINE  
Responsable QSE



## DECLARATION OF CONFORMITY

For the following product

**DC001**

**2021-01**

### **Type 3347 Hygienic Angle Valve**

The Type 3347 Hygienic Angle Valve meets the requirements of the Chinese food industries according to the following parameters.

The Valve meets the requirements of the regulation GB 4806.1-2016 & GB 31603-2015. Seals and metal parts underwent overall and specific migration testing whose conditions and results are listed on the next page.

The test on seals and metal parts comply with:

- the regulation GB 31603-2015 relative to good manufacturing practice for materials and articles intended to come into contact with food,
- the regulation GB 31604-2015 concerning general principle for the migration test,
- the regulation GB 5009-156-2016 relative to pretreatment method for food contact materials and articles,
- the regulation GB 4806.1-2016 on general safety requirements on food contact materials and articles.

The composition of the PTFE TFM 1705 granules used in the manufacture of the seals, in direct contact with the fluid, comply with:

- the regulation GB 4806.6-2016 on plastic resin intended to come into contact with food,
- the regulation GB 4806.7-2016 on plastic materials and articles intended to come into contact with food,

The composition of steel 1.4409 / A351 CF3M used in the manufacture of the metal parts, in direct contact with the fluid, comply with:

- the regulation GB 4806.9-2016 on metal materials and articles intended to come into contact with food.



### Seals in PTFE TFM 1705

#### Overall migration (OM)

The maximum limit on the migration has been tested and measured in accordance with the following table:

Expected service conditions	Food simulant	Duration	Temperature de tests	Maximum limit on the migration (mg/dm <sup>2</sup> )	Migration results (mg/dm <sup>2</sup> )	Surface to volume ratio (dm <sup>2</sup> /dl)
High-temperature thermal sterilization or distillation under T ≤ 121°C	10% ethanol	2 h	100°C	10	4.4	1
	4% acetic acid	2 h	Back flow temperature	10	6	1
	Vegetal oil	2 h	100°C	10	1.4	1

#### Specific migration (SM)

The maximum limit on the specific migration (SML) of substances authorized by the Regulation GB No. 4806.6 has been tested and measured in accordance with the following table:

Polymer name	N°	CAS N°	SML (mg/kg)	Status
PTFE= polytetrafluoréthylène	87	9002-84-0	0.05	OK
FEP = hexafluoropropylène	85	25067-11-2	0.01	OK

### Metallic parts in steel 1.4409 / A351 CF3M

The maximum limit on the migration of substances authorized by the Regulation GB 4806.9 has been tested and measured in accordance with the following table:

Expected service conditions	Food Simulant	Duration	Test temperature
High-temperature thermal sterilization or distillation under T ≤ 121°C	4% acetic acid	2h	Back flow temperature

Item	Results (mg/kg)	SML (mg/kg)	Status
As	0.002	< 0.04	OK
Cd	<0.001	< 0.02	OK
Cr	0.075	< 2.0	OK
Ni	0.065	< 0.5	OK
Pb	0.014	< 0.05	OK

#### Conclusions:

The migration tests such as defined in the Regulation GB 31604-1 and performed under the conditions above lead to the conclusions that the seals and metal parts can be used:

- for all foods such as specified in the Annex A Table 1 due to satisfactory results obtained with food simulants (table 1 & 2).



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- under test conditions: high temperature applications up to 121°C (cf. Table 6).

SAMSON REGULATION S.A.S

A handwritten signature in blue ink, appearing to read "Bruno Soulas", written over a horizontal line.

Bruno Soulas  
Head of Administration

SAMSON REGULATION S.A.S

A handwritten signature in blue ink, appearing to read "Joséphine Signoles-Fontaine", written over a horizontal line.

Joséphine Signoles-Fontaine  
QSE Manager



## KONFORMITÄTSERKLÄRUNG

DC016

Für folgende Produkte

2019-08

**Stellventile Typ 3241, 3244, 3249, 3251, 3252, 3256, 3347, 3321, 3349**

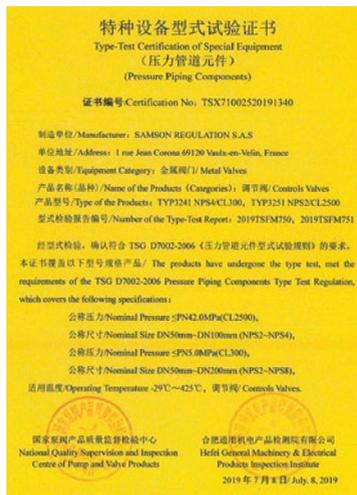
Zeugnis Nr.: TSX71002520191340

Bewertungsberichte N r.: 2019TSFM750-TYP3241  
und 2019TSFM751-TYP3251

Die Ventile 3241 und 3251 haben die Bewertungstests gemäß den Anforderungen der chinesischen Druckgeräte TSG D7002-2006 bestanden.

Infolgedessen erfüllen alle oben genannten Rückschlagventile die Anforderungen der TSG D7002-2006 für chinesische Druckgeräte gemäß den folgenden Merkmalen:

- DN 50 bis 200 PN ≤ 5 MPa (50 bar) oder NPS 2 bis NPS 8 Class ≤ 300,
- DN 50 bis 100 PN ≤ 42 MPa (420 bar) oder NPS 2 bis NPS 4 Class ≤ 2500,
- Betriebstemperatur: -29°C ≤ T ≤ 425°C.



SAMSON REGULATION S.A.

Bruno Soulas  
Leiter Verwaltung

SAMSON REGULATION S.A.

Joséphine Signoles-Fontaine  
Qualitätsmanager

# SAMSON REGULATION S.A.S.



1/1

**DC027**  
**2020-04**

## DECLARATION DE CONFORMITE DECLARATION OF CONFORMITY

符合性声明

La présente déclaration de conformité est établie sous la seule responsabilité du fabricant.  
This declaration of conformity is issued under the sole responsibility of the manufacturer.  
制造商对发布的符合性声明全权负责。

Nous certifions que les produits suivants en exécution standard :  
For the following products in standard execution:  
适用于下述型号的产品：

Type / type / 型号 : 2371, 3249, 3252, 3310, 3331, 3347, 3349, 3351, 3710, 3711, 5090, Samstation

sont conformes à la législation applicable :  
the conformity with the relevant legislation is declared with:  
声明符合相关法规：

**China RoHS 2.0 GB/T26572-2011**

Fabricant : SAMSON REGULATION S.A.S.  
Manufacturer : 1, rue Jean Corona  
制造商 69120 Vaulx-en-Velin  
France

Vaulx-en-Velin, le 20/04/2020

Au nom du fabricant,  
On behalf of the Manufacturer,  
制造商的代表人

SAMSON REGULATION S.A.S.

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Joséphine SIGNOLES-FONTAINE  
Responsable QSE  
QSE Manager  
QSE 负责人

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ISSUE DATE: January 26, 2009

CERTIFICATE AUTHORIZATION NUMBER: 1494



THIS IS TO CERTIFY THAT

Samson Regulation S.A.S.

1, rue Jean Corona - BP 140, Vaulx - e n-Ve lin 69120 , France

is hereby authorized to continue to apply the  
3-A Symbol to the models of equipment, conforming to 3-A Sanitary Standards for:

Number 53-06  
53-06 (Compression-Type Valves)

set forth below

CIP Models: 3347 Series with Var-ID codes xxxxxx-HY; 3349 Series with Var-ID codes xxxxxx-HY and 3249 Series with Var-ID codes xxxxxx-HY all fitted with actuator 3277 or 3379. Optional accessories include positioners 3724, 3730 or 3760, limit indicator 3776, pressure reducer 4708 and solenoid valves 3967 or 3963.

VALID THROUGH: **December 31, 2021**

Timothy R. Rugh  
Executive Director  
3-A Sanitary Standards, Inc.

The issuance of this authorization for the use of the 3-A Symbol is based upon the voluntary certification, by the applicant for it, that the equipment listed above complies fully with the 3-A Sanitary Standard(s) designated. Legal responsibility for compliance is solely that of the holder of this Certificate of Authorization, and 3-A Sanitary Standards, Inc. does not warrant that the holder of an authorization at all times complies with the provisions of the said 3-A Sanitary Standards. This in no way affects the responsibility of 3-A Sanitary Standards, Inc. to take appropriate action in such cases in which evidence of nonconformance has been established.

NEXT TPV INSPECTION/REPORT DUE: **November 2023**



Date of issue: 25 February 2019

Valid until: 31 December 2020

**EL Class I**

*EHEDG hereby declares that the product*

***Control angle valve type 3347 / Sealing PTFE***

*from*

*SAMSON REGULATION SA, 1 rue Jean Corona BP 140 , 69512 Vaulx-en-Velin, France*

*has/have been evaluated for compliance and meets/meet the current criteria for  
Hygienic Equipment Design of the EHEDG*

***Certificate No. EHEDG-C1800079***

Signed  \_\_\_\_\_ President EHEDG  
*Ludvig Joesefsberg*

Signed  \_\_\_\_\_ EHEDG Certification Officer  
*Mirjam Steenaard*

*EHEDG Secretariat  
Lyoner Straße 18  
60528 Frankfurt am Main  
Germany*

©EHEDG



## Appendix 3

### EHEDG Certification – Equipment Evaluation Form

Date: 07.02.2019

EHEDG File Number: EHEDG- C1800079

Certification Type: EL CLASS I

Applicant SAMSON REGULATION SA FRANCE

Equipment: Control angle valve

Type or model No/s.: type 3347 sealing PTFE

Other essential identification:

- Plug Valve, cast body - DN 25 to 100

- Plug Valve, bar stock body DN 32 to 100

**Evaluated by:**

Name: Nicolas ROSSI [AEO]

**Approved by:**

Name: IRENE LLORCA

Title: [AEO]

Date, Signature: 25.02.2019 

1. Results of inspection for compliance with the EHEDG Hygienic Design Criteria. Conclusion: <b>The equipment complies with the criteria.</b> <b>The use of the EHEDG Certification logo is justified:</b>	YES <input type="checkbox"/> MAYBE <input checked="" type="checkbox"/>
2. Evidence for compliance provided and convincing for Certification. Conclusion: <b>The equipment complies with the criteria where possible.</b> <b>The use of the EHEDG Certification logo is justified:</b>	YES <input checked="" type="checkbox"/>

Signature: 

Date: 27/02/2019

*The original of this form will be kept by EHEDG together with the application, the inspection report, the evidence provided and any other relevant documentation, as listed on the back.*

### Appendix 3

#### EHEDG Certification – Equipment Evaluation Form

No.	Description
1	EHEDG Certificate of Compliance
2	Contract to use the EHEDG Certification Logo for equipment
3	Appendix 1: Equipment intended for cleaning in place with liquids without dismantling
4	Appendix 2: Conditions for use of the EHEDG Certification Logo
5	Appendix 3: Equipment evaluation form
6	EHEDG hygienic design criteria evaluation report 008ACT2018
7	Drawings and technical detail of the : -Control angle valve type 3347 / Sealing PTFE - Original stamped (1049 0109) cast body - Control angle valve type 3347 / Sealing PTFE - Original stamped (1049-0046) bar stock body
8	Test report no. 005ACT2015 (cast body) and 008ACT2018 (bar stock body)
9	Example Logo EL class I

## 15 Annex

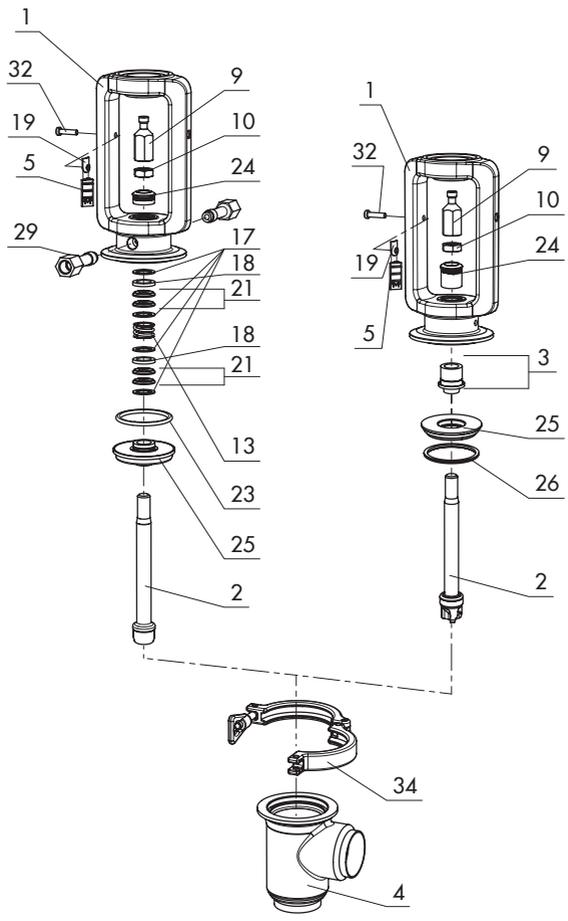
### 15.1 Tightening torques, lubricants and tools

► AB 0100 for tools, tightening torques and lubricants

### 15.2 Spare parts

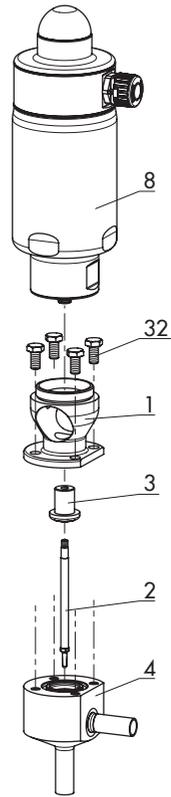
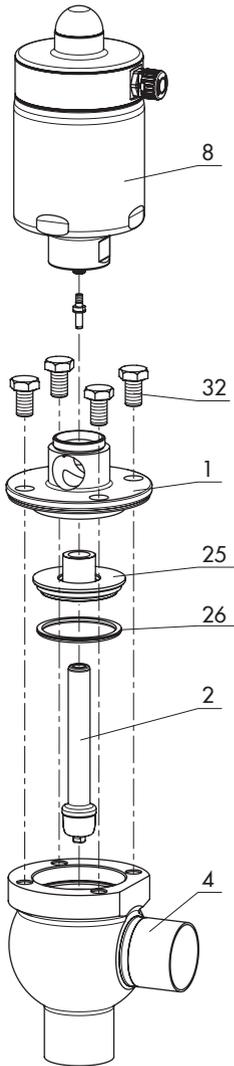
1	Valve bonnet with yoke	32	Screw
2	Plug with plug stem	34	Clamp
3	Plug stem seal	38	Blanking plug
4	Body	40	Seal
5	Travel indicator scale	41	Spacer
8	Actuator	110	Lubricant (food-grade grease)
9	Stem connector nut	112	Lubricant (food-grade grease)
10	Lock nut		
13	Spring		
17	Washer		
18	Spacer		
19	Hanger		
21	V-ring packing		
23	Seal		
24	Guide bushing/wiper ring		
25	Centering ring		
26	Seal		
29	Fitting/stopper		

# Cast body with PTFE seal and packing



Bar stock body with anti-crystallizing seal

Micro-flow valve version



### 15.3 After-sales service

Contact our after-sales service for support concerning service or repair work or when malfunctions or defects arise.

#### E-mail address

You can reach our after-sales service at [aftersalesservice@samsongroup.com](mailto:aftersalesservice@samsongroup.com).

#### Addresses of SAMSON AG and its subsidiaries

The addresses of SAMSON AG, its subsidiaries, representatives and service facilities worldwide can be found on our website ([www.samsongroup.com](http://www.samsongroup.com)) or in all SAMSON product catalogs.

#### Required specifications

Please submit the following details:

- Order number and position number in the order
- Type, model number, valve size and valve version
- Pressure and temperature of the process medium
- Flow rate in m<sup>3</sup>/h
- Bench range of the actuator (e.g. 0.2 to 1 bar)
- Is a strainer installed?
- Installation drawing



**EB 8097 EN**



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